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SPE OGA
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FINAL REPORT
FOR THE
SPE® OXYGEN GENERATOR ASSEMBLY (OGA)
(REFURBISHMENT OF THE TECHNOLOGY DEMONSTRATOR
LFSPE OXYGEN GENERATION SUBSYSTEM)

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BY

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**FINAL REPORT
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1.0 INTRODUCTION

The SPE Oxygen Generator Assembly (OGA) has been modified to correct operational deficiencies present in the original system, and to effect changes to the system hardware and software such that its operating conditions are consistent with the latest configuration requirements for the International Space Station Alpha (ISSA). The effectiveness of these changes has recently been verified through a comprehensive test program which saw the SPE OGA operate for over 740 hours at various test conditions, including over 690 hours, or approximately 460 cycles, simulating the orbit of the space station.

This report documents the changes made to the SPE OGA, presents and discusses the test results from the acceptance test program, and provides recommendations for additional development activities pertinent to evolution of the SPE OGA to a flight configuration. Copies of the test data from the acceptance test program are provided with this report on 3.5" diskettes in self-extracting archive files.

2.0 BACKGROUND

The SPE OGA, originally designated the LFSPE Oxygen Generation Subsystem, was delivered to Boeing Aerospace and NASA/MSFC in April 1990 as part of the Space Station Freedom Environmental Control and Life Support Systems (ECLSS) Technology Demonstration Program. The system was designed to safely and efficiently generate oxygen and hydrogen gas using a 12-cell liquid feed SPE water electrolyzer. Two distinct generation levels were specified and designed into the system: NORMAL and EMERGENCY. With the system in the NORMAL configuration, the oxygen generation rate was set for 11.12 lb_m/day, and for the EMERGENCY configuration, the rate was set for 14.72 lb_m/day. Oxygen and hydrogen gas were maintained at 200 and 160 psia, respectively, using a nitrogen reference system operating at a pressure of approximately 230 psia. The oxygen could be delivered to either a low pressure storage system or distribution bus, or delivered directly to the cabin atmosphere, while the delivery of hydrogen could be diverted to either a CO₂ reduction system or a waste gas vent. The

system was designed to use product water from the hygiene water processor as feed stock for the electrolysis process.

Performance testing of the LFSPE commenced in June 1990 in Building 4755 at NASA/MSFC. However, due to operational difficulties experienced by the system, and due to a reallocation of funding, the LFSPE only accumulated approximately 37 hours of test time. A second test program initiated in November 1990 saw the system operate for 529 hours: 169 hours with DI water; 270 hours with product water from a reverse osmosis system processing shower water; and 90 hours with DI water at the conclusion of the test program. The system operated for approximately 515 hours at the EMERGENCY oxygen generation rate, exhausting product gases at ambient pressure.

During the conduct of the two test programs at NASA/MSFC, the LFSPE experienced operational deficiencies that occasionally resulted in improper operation of the system and, in some cases, unscheduled test shutdowns. The issues identified as either problems or areas for concern were:

- Water carry-over from the hydrogen phase separator during start-up transient conditions
- Rising cell potentials while operating the system with water from the RO water processor
- Inadequate priming of the recirculation water loop pump
- Inaccurate flow sensor readings of the recirculating water loop
- Inadequate heat rejection from the recirculating water loop heat exchanger due to higher than expected cell potentials
- Failure of the three-way solenoid valves which divert the flow of generated gas to either a delivery or vent interface
- Blistering of hydrophobic membrane material in the oxygen phase separator, inhibiting gas transport
- Frequent alarm conditions triggered by the hydrogen sense cell of the hydrogen phase separator assembly
- Failed electrical contactor for the 4-way ball valve, resulting in incomplete valve travel

- Failed current control isolation board, resulting in reduced current to the electrolysis module and hence reduced gas output

During 1994, NASA/MSFC contacted Hamilton Standard to discuss a refurbishment program for the LFSPE that would address and correct the above listed deficiencies, and would incorporate design changes to the system hardware and software to address the most recent ISSA configuration. Specifically, the requirements changes that bore the largest impact on the system design were:

- Generation of oxygen while on the light side of the space station orbit
- Variable oxygen generation rates (7.4 lb_m/day nominal; rate to be variable $\pm 10\%$)
- Space station nitrogen interface reduced to 100 psia, maximum

Hamilton Standard proposed a refurbishment program to ION Electronics in April 1994. The goals of the program were to develop an SPE oxygen generator assembly that incorporated the design changes necessary to reflect the requirements for the ISSA, and to demonstrate flawless performance of the system during all aspects of operation. A contract to perform activities pursuant to the stated goals was awarded by ION in May 1994. The major elements of the program included:

- Conduct a baseline test of the as-received system to determine the status of key system components
- Refurbish the system to incorporate design changes necessary to correct system deficiencies, and provide variable oxygen generation rates and cyclic system operation
- Test the effectiveness of the design changes
- Provide field support of the unit once returned to NASA/MSFC

3.0 BASELINE TEST PROGRAM

A baseline test program of the returned LFSPE Oxygen Generation Subsystem was completed in September 1994. The objective of the baseline test was to note the performance of key system components, in particular the electrolysis cell stack, the oxygen and hydrogen phase separator assemblies, and the fan/heat exchanger assembly prior to system refurbishment. A copy of the master test plan for baseline testing of the unit is included as Appendix A. A copy of the test data from the baseline test is also included in the referenced appendix.

The system operated for 56.9 hours in the Process state, with 39 hours at the NORMAL rate (11.12 lb_m/day oxygen), and 17.9 hours at the EMERGENCY rate (14.72 lb_m/day oxygen). In general, the results from the baseline test program were comparable to those observed during the last test program conducted by NASA/MSFC in December 1990. Specifically:

- Water carry-over in the hydrogen phase separator was observed during start-up transient conditions. The typical volume of water observed during start-up was 30 - 50 ml.
- The recirculating water loop experienced pump priming problems during system start-up and shutdown depressurization transient conditions. In addition, the recirculating water loop bellows tank would occasionally expand to the first shutdown switch once gas generation had begun.
- The average cell potential for the 12-cell electrolysis stack operating at a current of 79 amps (Emergency oxygen generation rate) and a water exit temperature of 120°F was approximately 1.87-1.88 Vdc for both this and the previous test program. In addition, the performance of the fan/heat exchanger assembly was satisfactory for the duration of this test program as it was for the NASA/MSFC test program once testing with product water from the RO water processor was discontinued.
- The hydrogen sense cell alarm triggered a number of times during system start-up. Diagnostic testing of the stripper cells and sense

cell circuits revealed that the stripper cell power supply or its control circuit occasionally malfunctioned, resulting in the delivery of hydrogen-saturated water to the sense cell. A separate power supply was installed in the power supply cart for the duration of this test program, bypassing the original supply and control circuit. In addition, the shutdown associated with high sense cell currents was bypassed.

A number of minor discrepancies were also observed during the conduct of the test program, including low water feed rates from the feed pump resulting in a system shutdown due to a low level in the recirculation water loop bellows accumulator and BITE shutdowns of the process controller while changing setpoints. The discrepancies were logged in the test plan for future action once the refurbishment activity was underway.

4.0 SYSTEM REFURBISHMENT

Refurbishment of the OGA began in September 1994 at the conclusion of the baseline test program. The entire system was disassembled to the component level, with each item separately bagged to preserve its cleanliness. A summary of the refurbishment activities is presented below. A detailed description of the refurbished system and a narrative describing system operation are included as sections 4.11 and 4.12, respectively.

4.1 Hydrogen Phase Separator Refurbishment

The original hydrogen phase separator assembly employed a single hydrophilic membrane to effect the bulk fluid separation. However, during system start-up, water would become entrained in the gas outlet stream and would subsequently be delivered to the downstream hydrogen system. As the hydrogen generation pressure increased, the amount of water being carried over decreased until no water was present. Since the system achieved full production output in only a few minutes, the carry-over was attributed to the high gas velocities present in the hydrogen phase separator during this

transient condition, resulting in inadequate contact time with the hydrophilic membrane.

The hydrogen phase separator assembly was modified to incorporate dual hydrophilic-hydrophobic cavities, and successfully demonstrated proper fluid separation at all operating conditions of the revised system. A schematic of the refurbished hydrogen phase separator assembly is included as Figure 4.1-1. Water is transported across the hydrophilic membranes to the electrochemical hydrogen pumps, while the hydrogen gas flows through the hydrophobic membranes to the hydrogen pressure control system. A detailed description of the operation of this device is included in the System Description section of this report.

4.2 Electrolysis Cell Stack Refurbishment

During the November 1990 test program at NASA/MSFC, the LFSPE was tested for a total of 529 hours. The test was divided into three modules:

- 169 hour test with DI water
- 270 hour test with product water from a reverse osmosis system processing shower water
- 90 hour test with DI water

The first 169 hours of the test program saw a steady average cell potential for the 12-cell electrolyzer. However, during the 270 hour test with processed hygiene water, the average cell potential rose steadily. Eventually the average cell potential exceeded the design point of the heat rejection system of the LFSPE, and the recirculating water loop temperature began to increase above its 120°F operating point. An additional fan was located in the vicinity of the system fan/heat exchanger assembly to provide additional cooling capacity. Once the water feed was returned to DI water, the average cell potential began to decrease steadily, and continued to decrease for the remainder of the 90 hour DI water test. In addition, the recirculating water loop returned to its original design operating point of 115-120°F.

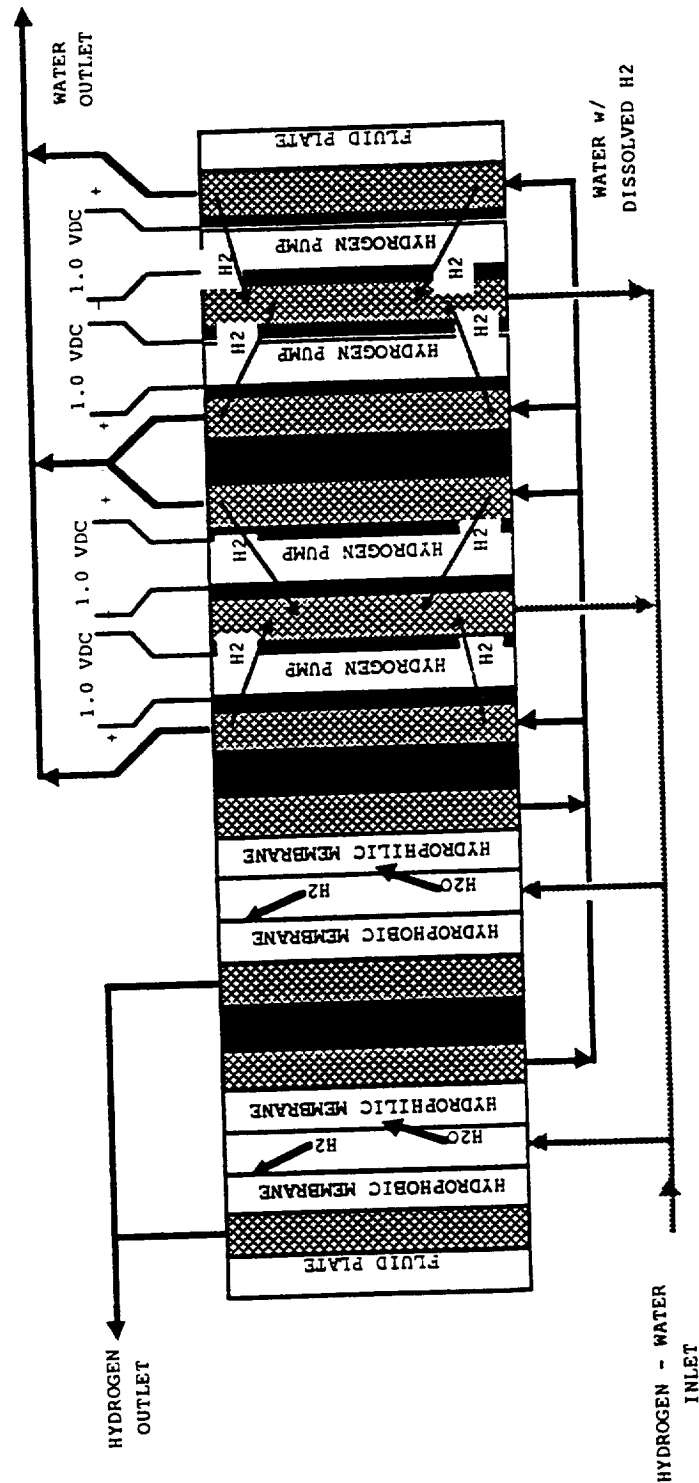


FIGURE 4.1-1
HYDROGEN PHASE SEPARATOR

At the conclusion of the test program, three theories were proposed to explain the increase in the average cell potential:

- i) Relaxation of the cell stack preload, resulting in higher screen to cell membrane contact resistance.
- ii) Heavy metal ion contamination of the solid polymer ion exchange membrane.
- iii) Organic contamination of the cell anode, resulting in a higher cell polarization.

The first explanation was eliminated from consideration due to the fact the cell potentials began to recover during subsequent testing with DI water. The second explanation was also considered unlikely since: the water analyses of the feed water did not indicate any heavy metal ion contamination; the conductivity sensor in the subsystem did not detect any breakthrough in the deionizer bed, and; because heavy metal ion contamination is essentially irreversible, the cell potentials would not have recovered when the feed stock was changed to DI water. The latter explanation, organic contamination, was considered the most likely scenario. Organic contamination would result in a masking of the anode of the electrolysis cell, resulting in increasing cell operating potential as the contamination continued to build. The anode catalyst is capable of oxidizing smaller organic molecules, resulting in the evolution of CO_2 and H_2O , but has a more difficult time with the larger organic molecules. Eventually, the entire anode surface will reach some equilibrium level of contamination. At that point, an equilibrium potential will be established, but at a higher level. This theory was supported by the fact that, when the feed stock was changed back to DI water, the cell potentials began to decrease, indicating oxidation of and a decrease in the amount of material on the anode surface of the cells.

During 1991, an IR&D program was initiated in an attempt to understand these test results. Electrolysis cells were challenged with a variety of different feed waters:

- i) An ersatz recipe that duplicated the product water from the Space Station Freedom hygiene water processor.
- ii) Actual product water from the Space Station Predevelopment hygiene water processor, processing shower and laundry water.
- iii) Water solutions containing the maximum concentrations of contaminant species from water analyses of the feed water used during the 270 hour test program (see Table 4.2-I).

The test programs with the first two water feeds resulted in stable cell operating potentials. However, while testing electrolysis cells with water containing ammonia and Igepon TC-42 at the concentration levels listed in the table, the cell potential rose at a rate similar to what was observed during the 1990 test program. Testing of these cells continued until an equilibrium potential was reached. The feed water to these cells was then converted to DI water, and the cell potential began to decrease steadily as it had during the 1990 test program. As a result, it was concluded that the cause for the steadily increasing cell potentials observed during the 1990 test program was contamination of the feed water with ammonia and Igepon TC-42. The IR&D program also indicated that the cells could operate with these contaminants present in the feed water; the penalty, however, would be a higher, but reversible, cell potential.

A new 18-cell electrolysis cell stack was built as part of the SPE OGA refurbishment program. The number of cells increased to 18 in order for the new module operating at ambient temperature to maintain the same overall thermal efficiency as a 12-cell stack operating at 120°F. The cell stack was assembled using new hardware, including all frames, screen assemblies and end plates. Since the feed water for the OGA has been changed from hygiene quality water to potable water, it is anticipated that the performance of the electrolysis cells should be stable, resulting in essentially flat cell potential profiles as was witnessed during the 740 hour test program.

**TABLE 4.2-I
1990 LFSPE OXYGEN GENERATION SUBSYSTEM
FEED WATER ANALYSES ***

COMPONENT	CONCENTRATION (PPM)
Zinc	.003
Sodium	1.33
Calcium	.031
Iron	.391
Chromium	.268
Cadmium	.083
Manganese	.386
Potassium	24.3
Chloride	283
Sulfate	288
Fluoride	9.7
Nitrate	.53
Ethanol	1.56
Toluene	23
Triiodomethane	14
Methanol	1.19
Ammonia	12.9
Detergent (Igepon TC-42)	1.18

* Source: Boeing Test Laboratories
Concentration level represents the highest recorded by the Boeing laboratory for the species indicated

4.3 Recirculating Water Loop Refurbishment

The recirculating water loop was modified to: correct inadequate pump priming at system start-up; correct loss of pump prime during system shutdown; incorporate a thermal flow switch to monitor the water flow rate to the stack, and; install a liquid-to-liquid heat exchanger to reject waste heat from the water electrolysis process.

4.3.1 Pump priming

The initial configuration of the LFSPE Oxygen Generation Subsystem included a deionizing bed and a ten-inch cartridge filter in the recirculating water loop, and an in-stack oxygen phase separator assembly. However, since the system operated at 200 psia, during system depressurization the amount of oxygen evolved from the water loop nearly exceeded the volume expansion capability of the metal bellows accumulator. In order to reduce the volume of the water loop, both the deionizer bed and the filter were removed and replaced with jumpers. In addition, since the in-stack oxygen phase separator had failed during in-process testing at Hamilton Standard, a separate unit had to be installed on the outside of the package. Hence, the packaging of components in the system was never optimized, resulting in pockets of gas trapped in various parts of the recirculating water loop. A separate purge routine was implemented to force gas out of the loop to allow the pump to prime, but its performance was marginal.

In order to ensure adequate priming of the pump during all aspects of system operation, a number of changes to the recirculating water loop were implemented. First, the operating pressure of the loop was reduced from 200 psia to near ambient in order to reduce the amount of oxygen dissolved in the water that would subsequently evolve during a system shutdown. Second, the components in the loop were packaged closely together to minimize loop volume and eliminate potential gas traps wherever practical. And finally, the recirculation water loop metal bellows accumulator was also modified to operate with a fixed nitrogen charge such that the pump inlet is

always maintained above ambient pressure. Testing of the refurbished system demonstrated correct pump priming even after a loss of power shutdown.

4.3.2 Flow sensing

A flow sensor is included in the water recirculation loop to ensure power is not applied to the cell stack when there is no water flow. The system originally incorporated a Teflon turbine flowmeter; however, after approximately 100 hours of operation the Teflon bearing failed resulting in erratic readings from the sensor. The sensor was returned to the vendor and refurbished with a harder bearing and shaft material; however, the sensor continued to provide erratic readings. As a result, the flow sensor was removed from the system, and a pressure sensor was installed just upstream of the electrolysis module. This sensor, in conjunction with a pressure sensor already installed downstream of the electrolysis module, was used to calculate a pressure drop across the module. The pressure drop data was then used to correlate a water flow rate through the module. However, since the characteristics of the two-phase flow downstream of the module varied with pressure, temperature and gas generation rate, the measurement was somewhat crude and inaccurate.

In order to improve the reliability of the recirculating water flow measurement, a thermal flow switch was installed upstream of the electrolysis module. The flow switch determines whether a fluid is flowing at the preset rate by sensing the temperature difference between two precision resistors mounted within the housing of the flow monitor. One resistor is located in the sensor tip, closest to the flowing fluid and heated to a temperature that is a few degrees higher than the temperature of the fluid. The second resistor is located such that it is affected only by the temperature of the fluid. Cooling of the heated resistor is a function of how fast heat is conducted away by the flowing medium. Therefore, the difference in temperature between the two resistors provides a measurement of fluid velocity past the sensor probe.

The controller for the flow sensor is located inside the Electrical Interface Box (EIB) which is mounted to the side of the system package. Potentiometers on the controller allow the user to adjust the setpoint over a wide range of fluid velocities. For the refurbished OGA, the controller was set such that a flow rate of approximately 30% of normal, or 0.2 GPM, for a period of 10 seconds would trigger an automatic shutdown of the system and provide a low flow message to the user. The flow switch performance was satisfactory throughout the 743 hour test program following system refurbishment. The loss of recirculating water flow events recorded by the flow switch during the test program were not sensor related, but were in fact the result of reduced flow conditions caused by 1-g gas traps present in the system hardware (see section 5.2).

4.3.3 Liquid-to-liquid heat exchanger

With the oxygen operating pressure reduced to near-ambient conditions, the oxygen/water mixture leaving the cell stack must be cooled to at or below ambient temperature to assure that moisture condensation does not occur in the oxygen delivery plumbing. Heat rejection in the original system was provided by an ambient air cooled heat exchanger in the recirculating water loop located upstream of the cell stack where there was no undissolved oxygen flowing. In order to cool the recirculating water loop at this location in the refurbished system, a heat sink much lower than the ambient air temperature must be used. This would also require that the cell stack operate at very low temperatures, reducing its efficiency or making it necessary to add more cells.

The refurbished system employs a liquid-to-liquid heat exchanger located downstream of the cell stack where there is a mixture of gaseous oxygen and recirculating water. The heat exchanger uses the 65°F vehicle coolant loop as the heat sink to reduce the delivered oxygen temperature to less than 70°F at the maximum electrolysis rate during light side operation and with all 18 electrolysis cells operating at their maximum potential of 2.5 Vdc. The new heat exchanger capacity is in excess of 800 watts, almost 3 times the capacity of the original air-cooled heat exchanger assembly. At a coolant flow rate of

500 lb_m/hr, the pressure drop on the shell side of the heat exchanger is less than 1 psid. Performance of the heat exchanger through the duration of the 743 hour test program was satisfactory, with no condensation observed in the oxygen delivery line.

4.4 3-way Solenoid Valve Refurbishment

The original system employed 3-way solenoid valves at the oxygen and hydrogen outlets to divert the flow of gas to either a storage system or vent interface. However, during testing at Hamilton Standard and NASA/MSFC, these valves failed due to overheated coils. When the solenoids were originally specified by the valve supplier, he neglected to inform the solenoid supplier that the coils would be enclosed in a stainless steel housing. As a result, the coils operated at a much higher temperature than their design point and eventually burned out.

The valve supplier replaced the burned coils and provided a driver circuit for each of the valves to prevent overheating of the solenoid coils. The driver circuit allows full power to the solenoid for .375 to .750 seconds upon initial application of voltage at the input terminals. The voltage then automatically drops to approximately 50% of full voltage, resulting in a hold-in current of approximately 25% power until the input voltage is removed. Voltage (and consequently power) reduction is achieved by pulse width modulating the input signal. The driver circuit includes a full wave rectifier, AC line voltage transient protection, and solenoid transient suppression. With the refurbished system, only one valve is required, that being at the hydrogen outlet. The 3-way valve allows the user to divert hydrogen flow to a downstream CO₂ reduction system in the event the OGA is included in an air revitalization integrated test program, or to a laboratory vent where the nitrogen purge gas at system start-up and shutdown is also vented. During the recently completed test program at Hamilton Standard, the refurbished valve and driver circuit operated for approximately 600 hours without failure, whereas the valve without a driver circuit typically failed after 50-100 hours of operation.

4.5 Oxygen Phase Separator Refurbishment

During in-process testing of the original Technology Demonstration Oxygen Generation Subsystem, the oxygen phase separator assembled as part of the electrolysis cell stack experienced a failure due to an inability to transport gas across the hydrophobic membrane. The results of a separate test program of hydrophobic membranes indicated that the material was susceptible to blistering under certain conditions. Once formed, the blisters hindered the transport of gas across the membrane. It was theorized and later confirmed by test that water vapor condensing within the microporous structure of the membrane caused the blisters to be formed. In order to alleviate this problem, the oxygen phase separator was redesigned so that the gas side of the hydrophobic membrane was kept warmer relative to the two-phase side, thereby preventing condensation. Rather than disassembling the failed oxygen phase separator from the cell stack-manifold assembly, an external phase separator was built and installed into the unit, with the failed unit bypassed with additional plumbing.

During refurbishment of the OGA, both the external and the original in-stack oxygen phase separator were disassembled. As originally suspected, the in-stack phase separator, which had used what was later determined to be blister-prone "S" material, had evidence of blistering over approximately 50% of its surface. The external phase separator, which used the less susceptible "X" material coupled with favorable differential temperature characteristics, exhibited no signs of blistering. As a result, the phase separator hardware was rinsed with clean DI water and reassembled with new hydrophilic membranes. The hydrophobic membrane from the external phase separator assembly was also rinsed with clean DI water and returned to the assembly. Performance of the oxygen phase separator assembly was satisfactory during all aspects of system operation, including transitioning from standby to full production back to standby.

4.6 Hydrogen Sense Cell Alarms

During the 529 hour test program at NASA/MSFC and subsequent baseline testing at Hamilton Standard, the hydrogen sense cell triggered numerous shutdowns due to high cell currents. Two causes for the shutdowns were identified:

- 1) A malfunctioning power supply and/or control circuit for the four stripper cells
- 2) Formation of a hydrogen bubble in the water outlet header of the separator assembly and subsequent migration of this bubble to the sense cell compartment

In the first case, if the four stripper cells failed to charge properly, then hydrogen-saturated water would be delivered to the sense cell, triggering an alarm condition. This condition appeared to occur on a number of occasions when it seemed the power supply was unable to adequately charge the four stripper cells. It was later determined that the circuit controlling the charging rate for the stripper cells had malfunctioned. The circuit was repaired, and correct operation of the power supply, control circuit and hydrogen pump cells was subsequently demonstrated as part of this refurbishment effort.

The second case, that of bubble migration, occurred on several occasions when the four stripper cells appeared to be operating within normal parameters. However, this became a nonissue when, after completing a revision to the Failure Mode and Effects Analysis (FMEA) it was determined that sufficient fault detection had already been incorporated into the system and therefore a sense cell was not required in the assembly. During the refurbishment of the hydrogen phase separator, the sense cell was removed from the assembly.

4.7 4-way Ball Valve Mechanical Contactor

Early in the test program at NASA/MSFC the LFSPE experienced a number of shutdowns associated with improper hydrogen phase separator performance and improper feed water bellows fill rates. After performing a number of diagnostic tests it was determined that the mechanical contactor driving the 4-way ball valve had been seriously pitted due to current levels higher than the rating of the contacts. The contactor was subsequently replaced with a unit having contacts rated at 6 amps, the in-rush current rating of the valve. The valve performance was satisfactory throughout the remainder of the test program.

Since the contactor rating was identical to the valve in-rush current, additional margin on the contact rating was required to prevent a reoccurrence of the previous failure. A contactor with a 10 amps rating was installed and performed satisfactorily throughout the 743 hour test program.

4.8 Current Control Isolation Board

The current control isolation board failed to provide the correct signal to the electrolysis power supplies while the system was set at the EMERGENCY oxygen production level during the NASA/MSFC test program. As a result, the board had to be modified during the test program to include a potentiostat to fine tune the current level to the electrolysis cell stack. In addition, it was believed that the current control signal may have been drifting due to thermal variations within the power supply cabinet. However, diagnostic testing of the circuit at the conclusion of the test program revealed that the board had been assembled incorrectly and was therefore clamping the control signal to a value lower than what was required to command the power supplies at the EMERGENCY generation level. The error in the control isolation board was corrected and the board reinstalled into the power supply cabinet. The board functioned properly during the recently completed test program.

4.9 Cyclic & Variable Oxygen Generation

Changes to the requirements for the OGA for the ISSA dictate that operation of the unit be limited to the daylight side of the orbit only and that the oxygen production rate be variable. Hamilton Standard revised the control software to allow the user to input light side/dark side time duration along with the total oxygen production requirement on a per day basis. The inputs to the control software can be made via the Modify/View Operation screen available on the Command and Display Unit (CDU) or host system via the RS-232 port and are described in detail in the Operations Manual. Based on these inputs the system software calculates the oxygen generation rate required during the system "on" times. During dark side operation, the system software reduces the current to the module to a trickle value of 1 amp, sufficient to maintain a charge on the electrolysis cells. The recirculating water pump, feed water management and system instrumentation remain active during this standby period. Full production resumes at the conclusion of the dark period.

The SPE OGA control software allows the user to select a daily oxygen production rate of 6.66 to 8.14 lb_m/day (7.40 lb_m/day \pm 10%), LIGHT side duration of 50 - 60 minutes, and DARK side duration of 40 - 30 minutes. When transitioning from LIGHT to DARK, the current level to the electrolysis cell stack instantaneously drops from its generation level to the standby level of 1 amp. Once the duration of the DARK side has expired, the current to the electrolysis module begins to ramp up, increasing 5 amps every 5 seconds until the required current for the requested production level is attained. Typically, the time to reach full output is on the order of 40 seconds. The ramping rate is limited to the performance of the differential back pressure regulator controlling the hydrogen phase separator. Increasing the current ramping rate resulted in excessive differential pressures across the hydrophilic membranes in the phase separator. The high differential pressures can be attributed to the fact that, while the hydrogen pressure which provides the reference to the regulator returns to its full production level in the manner of a few seconds, the water pressure typically lags thereby causing the high differential pressure. If faster ramping rates are

required for the space station, the regulator can be replaced with a unit offering a faster response, the water volume on the hydrogen phase separator can be reduced, or a combination of both can be implemented.

During the acceptance test program, the SPE OGA was operated at the minimum, nominal, and maximum daily oxygen production schedule and at various LIGHT/DARK configurations. Gas production rates were verified with a wet test meter. Detailed test results are included in the Master Test Plan included in Appendix B of this report.

4.10 Nitrogen Interface Pressure

The original oxygen generation subsystem was designed to safely generate oxygen at pressures up to 200 psia and hydrogen at pressures up to 160 psia. Careful control of the generated gas pressures was maintained by a nitrogen reference system operating approximately 20-30 psid above oxygen pressure such that a pressure hierarchy of nitrogen over oxygen over hydrogen was always maintained. With the electrolysis module operating at a maximum temperature of 120°F, expanding the product gases to the pressure levels originally specified for Space Station Freedom provided oxygen and hydrogen at their required dew points. However, with the reduction of the nitrogen interface to 100 psia maximum, the hardware and software for the pressure control system had to be modified to reflect lower operating pressures.

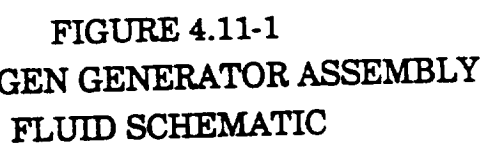
The system hardware was modified to generate oxygen at near ambient pressure for delivery directly to the crew cabin of the space station. Humidity control of the oxygen is attained by incorporating a liquid-to-liquid heat exchanger immediately upstream of the oxygen-water phase separator, and the drop in gas pressure when exhausting oxygen from the phase separator to the cabin. The heat exchanger was sized to operate from the vehicle 65°F coolant loop. The nitrogen serves as a purge gas for the hydrogen circuit during start-up and shutdown transients, and as a reference system controlling hydrogen pressure to 25 psig minimum. Operating the cell stack at near ambient temperature, coupled with the slightly elevated operating pressure, maintains the hydrogen free of any condensate.

The system software was extensively modified to incorporate lower pressure operation. Reference pressure measurements between nitrogen and oxygen were eliminated, and those between nitrogen and hydrogen were replaced with direct pressure readings. In addition, the redundancy required for nitrogen control of the oxygen system was eliminated with the drop in oxygen pressure to ambient. Control setpoints for nitrogen, as well as shutdown levels associated with fluid over and under pressure, were revised to reflect the decrease in nitrogen pressure. The hardware and software revisions to the nitrogen reference system performed satisfactorily during the conduct of the acceptance test program, demonstrating the capability of the refurbished SPE OGA to operate from the 100 psia ISSA nitrogen interface.

4.11 System Description

The refurbished SPE Oxygen Generator Assembly has been designed to safely produce oxygen and hydrogen gas from the electrolysis of water. The oxygen gas is generated and delivered at ambient pressure directly to the environment, while the hydrogen is generated at slightly elevated pressure for possible delivery to a CO₂ reduction system. A schematic of the fluid system is presented in Figure 4.11-1. The SPE OGA includes all valves, regulators, sensors and other controls for safe operation of the system.

The cell stack is a liquid anode feed water electrolyzer consisting of 18 SPE water electrolysis cells assembled in a bipolar arrangement between two compression end plates. A simplified schematic of a liquid anode feed cell is depicted in Figure 4.11-2. In the electrolysis process, liquid water is fed to the anode, or oxygen compartment, where it is electrolyzed to produce gaseous oxygen, hydrogen ions, and electrons. The hydrogen ions, or protons, are transported across the ion exchange membrane and the electrons travel through the external electrical circuit to the cathode. These protons are fully hydrated and deliver water to the cathode side of the membrane. The electrons combine with the protons to form gaseous hydrogen at the cathode. Excess water is pumped through the anode compartment to remove heat generated by the electrolysis process.



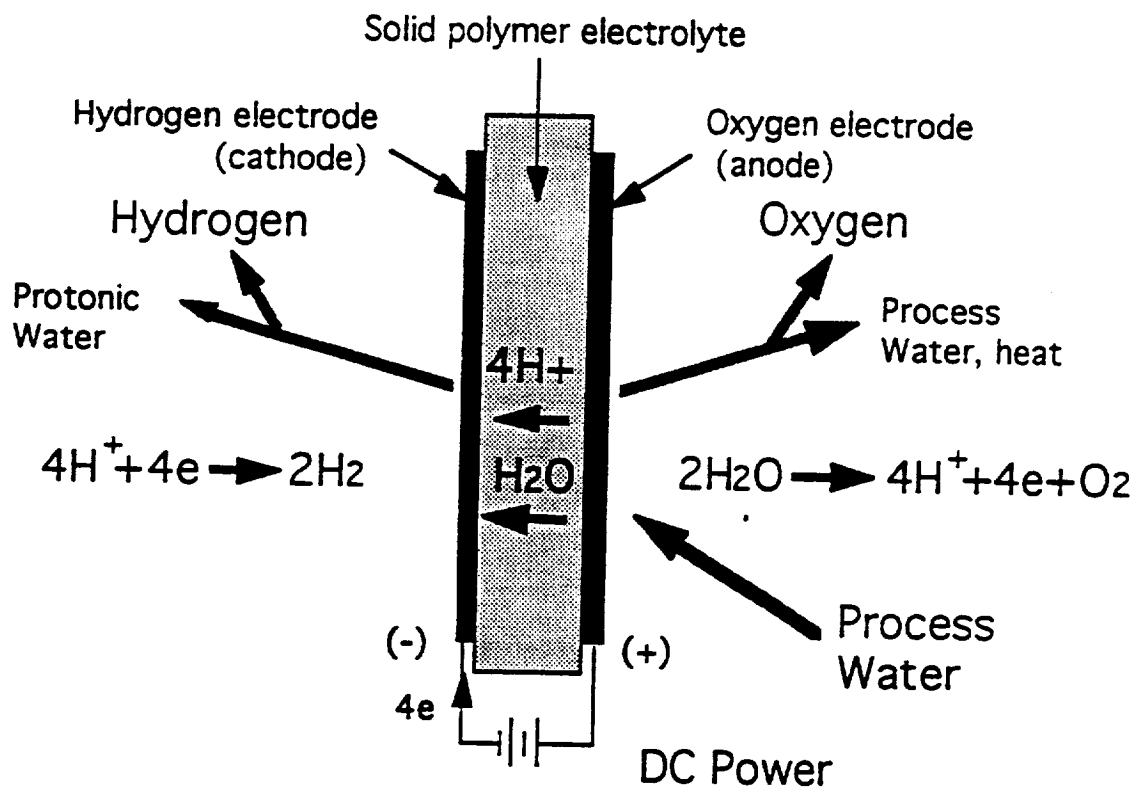


FIGURE 4.11-2
LIQUID ANODE FEED
SPE WATER ELECTROLYSIS CELL

Oxygen and hydrogen are generated at a stoichiometric ratio and at a rate proportional to the cell current. In order to satisfy the nominal daily oxygen requirement of 7.4 lb_m/day with a light side/dark side duty cycle of 53 minutes on/37 minutes off, the SPE OGA will generate oxygen at an instantaneous rate of 12.57 lb_m/day. Control of the daily oxygen production requirement, as well as the light side/dark side duty cycle, resides in the system controller and can be accessed through the Modify/View Operation screen of the Command & Display Unit. Additional control is also afforded to the host computer via the RS-232 data bus as defined in the Operations Manual.

The oxygen-water stream exiting the electrolysis cell stack enters a shell and tube liquid-to-liquid heat exchanger (Item 554A) to reject waste heat from the electrolysis reaction and to reduce the dew point of the oxygen gas. The heat exchanger is designed to operate using 65°F water at a flow rate of 500 lb_m/hr as the coolant. Temperature sensors located at the inlet (Items 736-1 and 736-2) and exit (Items 762-1 and 762-2) of the heat exchanger monitor its performance.

The two-phase stream enters the oxygen/water phase separator (Item 907) to deliver water free oxygen to the oxygen delivery system while oxygen free water is returned to the water recirculation loop. Figure 4.11-3 depicts the components of the oxygen/water phase separator. The two-phase mixture is separated in two stages: in the first stage are located six hydrophilic membranes that allow water to wick through but, because of their high bubble point, the membranes will not allow gas to flow through. The fluid exiting the two-phase cavity is mostly gas with a small amount of water carry-over. The fluid is directed to the second stage, or "polishing" section of the separator. The polishing section contains a hydrophilic and hydrophobic membrane, where the remaining water is returned to the water recirculation loop. The oxygen gas is delivered to the oxygen delivery system through the hydrophobic membrane. Because the hydrophobic membrane has a high water intrusion pressure (an attribute similar to the bubble point of a hydrophilic membrane), the oxygen gas is delivered free of any liquid water. A differential pressure sensor (Item 709) monitors the performance of the

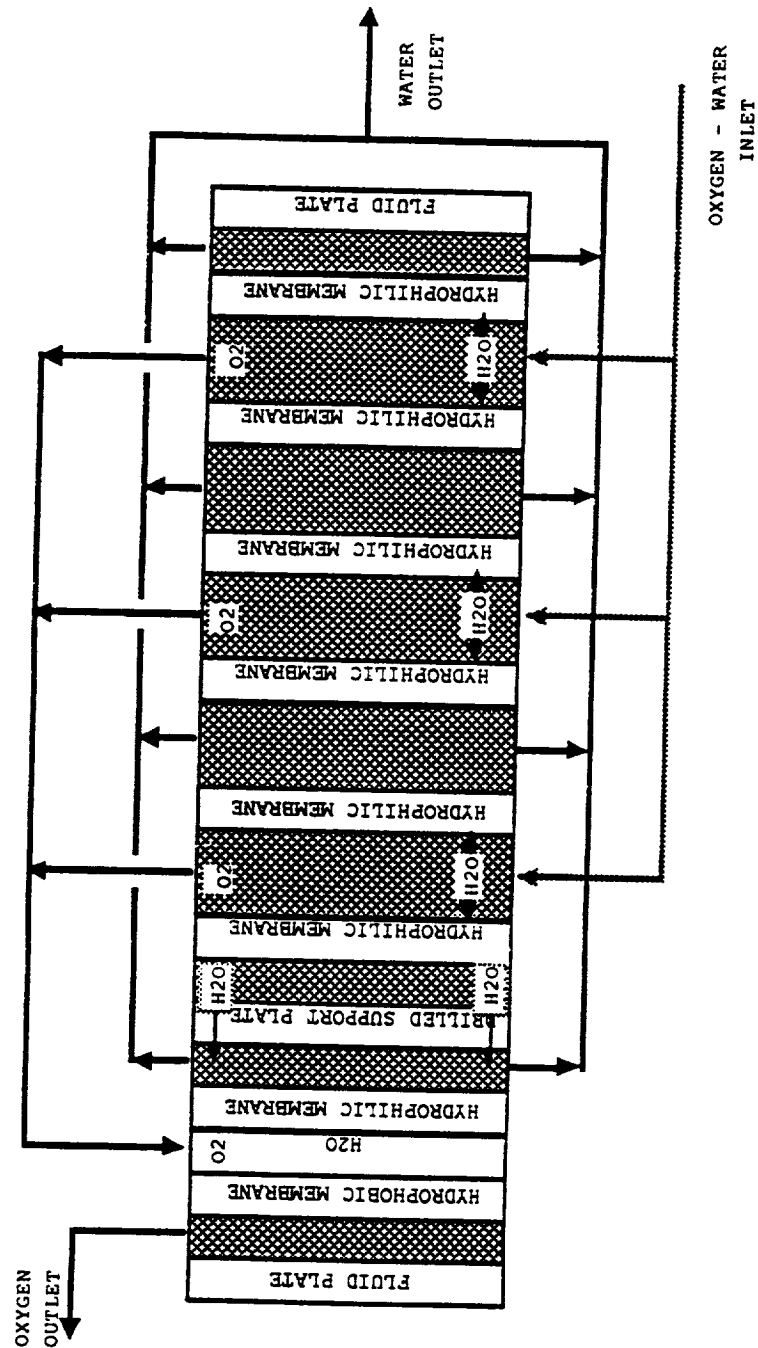


FIGURE 4.11-3
OXYGEN PHASE SEPARATOR

hydrophilic elements of the phase separator, and initiates a shutdown should the pressure drop exceed a specified value (typically, less than half of the membrane bubble point). The operating pressure of the water recirculation loop is lower than the water intrusion pressure of the hydrophobic membrane under all operating conditions. Water exiting the oxygen-water phase separator is returned to the electrolysis cell stack by a gear pump driven by a brushless DC motor (Item 463). Water flow to the module is monitored by a flow switch (Item 745) located immediately upstream of the cell stack. The flow switch will remove current to the module and initiate a system shutdown should the water recirculation rate drop below a predetermined value.

A metal bellows accumulator (Item 606) which serves as a feed tank for the electrolysis cell stack and an expansion volume for the water recirculation loop during the system start-up transient is located immediately downstream of the oxygen-water phase separator. As a feed tank, the metal bellows stroke is minimal, operating between approximately 10 and 15 cubic inches of volume. When the level in the tank falls below 10 cubic inches, the feed pump (Item 464) is activated until the tank attains a level of approximately 15 cubic inches at which point the feed pump is turned off. As an expansion volume, again the stroke of the bellows is minimal, with typical expansion values of 10 cubic inches or less. When the system is started the water recirculation loop is devoid of all gas. However, as power is applied to the electrolysis cell stack, the oxygen gas bubbles generated within the cell cavities cause an expansion in the volume of the loop, resulting in an expansion of the bellows tank. The bellows tank expansion continues until the gas bubbles reach the oxygen phase separator, at which point the bellows begins to recollapse to its normal operating range.

The oxygen gas produced in the SPE electrolyzer is free of hydrogen, with purities of 99.5% or greater typically measured. Since the SPE OGA has been designed to operate with hydrogen pressure always greater than oxygen pressure, redundant combustible gas sensors (Items 746-3 and 746-4) located at the oxygen outlet interface constantly monitor the oxygen for hydrogen and initiate a shutdown should the hydrogen level in the oxygen exceed 50% of the lower explosive limit (LEL). A pressure sensor (Item 7061) initiates a

shutdown should an obstruction occur in the delivery line, and a relief valve (Item 126A) provides redundancy in the event of a failed pressure sensor.

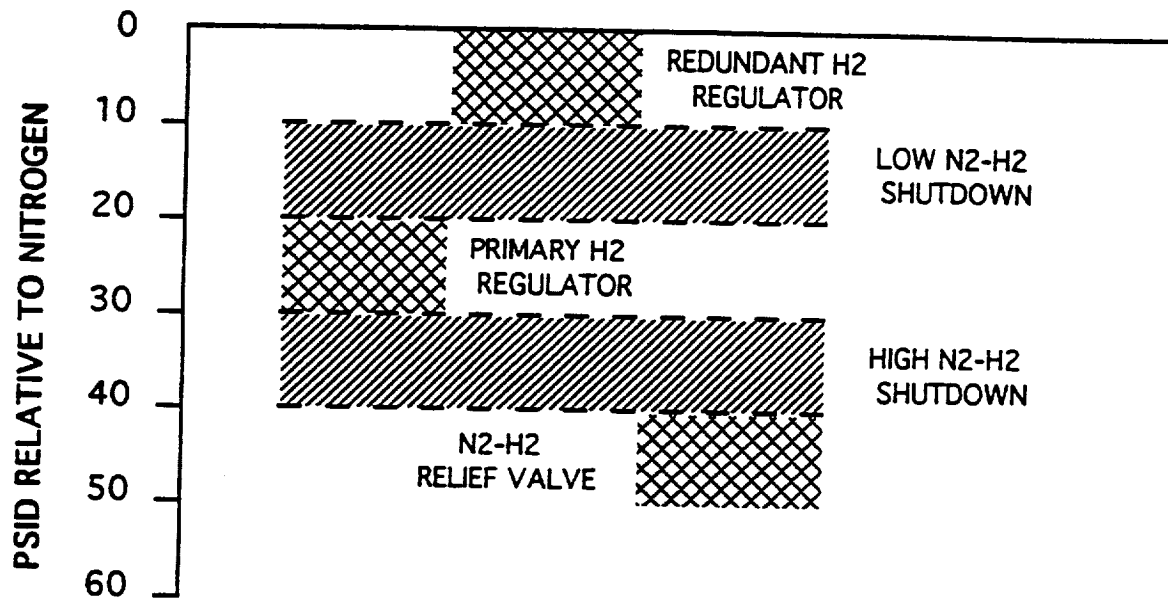
The hydrogen-water exiting the cell stack is mostly hydrogen gas by volume with a small amount of liquid water present from protonic pumping in the ion exchange membrane. The hydrogen/water phase separator contains two cavities, each containing a hydrophilic and hydrophobic membrane, and is similar in design and operation to the polishing section of the oxygen/water phase separator. Figure 4.1-1 depicts the design of the hydrogen/water phase separator. The hydrogen gas passes through the hydrophobic membrane to the hydrogen valve manifold containing the pressure control system, and the water is delivered to the "stripper" section of the phase separator. The stripper section contains four electrochemical hydrogen pumps that remove dissolved hydrogen from the water before it is returned to the water recirculation loop. The electrochemical hydrogen pump uses an SPE membrane and electrode assembly similar to the electrolysis membrane and electrode assembly. The degassed water is subsequently delivered to one of two metal bellows accumulators (Items 605-1 and 605-2) after dropping in pressure through a negative bias back pressure regulator referenced to hydrogen (Item 130). A differential pressure sensor (Item 708) monitors the performance of the hydrophilic element of the phase separator and performs a similar function to its oxygen phase separator counterpart. In addition, the performance of the electrochemical hydrogen pumps is monitored by individual voltage and current sensors and initiate a shutdown of the system should the values for these parameters fall outside predetermined limits.

As stated previously, the water exiting from the separator is stored in one of two metal bellows accumulators (Items 605-1 and 605-2). Two tanks, in conjunction with the four-way ball valve (Item 003), are provided for fault isolation in the event of a failure of the hydrogen phase separator that is undetected by either the differential pressure sensor or the stripper cell voltage and current monitors. While water is being fed to one tank from the phase separator the second tank is providing water, as required, to the water recirculation loop via the feed water pump (Item 464). Employing two tanks in this manner ensures that hydrogen gas is not introduced into the system

anode loop, where it would subsequently flow into the oxygen delivery system. As an additional back-up, redundant combustible gas sensors in the delivery system would detect hydrogen carry-over into the anode loop and initiate a system shutdown.

Hydrogen pressure control is maintained by a differential back pressure regulator referenced to nitrogen. Figure 4.11-4 shows the differential pressure control band. The primary hydrogen regulator (Item 120) maintains hydrogen operating pressure 25 psid below nitrogen. Hydrogen pressure control is monitored by a pressure sensor (Item 749); shutdown of the SPE OGA will occur if hydrogen pressure drifts above or below the normal band of the primary regulator. Mechanical backup for both high and low differential pressure is provided by the redundant differential back pressure regulator (Item 127) and relief valve (Item 125), respectively. If the primary regulator fails closed and either the hydrogen pressure sensor or controller fails to detect it, the redundant back pressure regulator will open to ensure nitrogen pressure is maintained above hydrogen. Conversely, should the primary regulator fail open and either the system instrumentation or controller fails to detect it, the nitrogen-hydrogen relief valve opens to introduce nitrogen into the hydrogen circuit to ensure hydrogen pressure is always maintained above oxygen pressure. A three-way solenoid valve (Item 005) at the regulator outlet directs flow to either the hydrogen outlet interface during normal processing, or to the vent interface during shutdown of the system.

As mentioned previously, nitrogen is used as a reference pressure for the hydrogen pressure control system. The nitrogen is also used as a purge gas during start-up and shutdown transient conditions: during start-up, the nitrogen purges any air from the hydrogen lines and, during shutdown, it purges hydrogen from the same lines. Nitrogen is introduced from the facility through a normally closed solenoid valve (Item 051A). A pressure sensor (Item 7062) monitors the nitrogen pressure and controls the operation of the solenoid valve. A nitrogen accumulator provides sufficient purge volume to safely and effectively purge the hydrogen circuit during start-up and shutdown. Purging of the hydrogen circuit is accomplished by removing



ASSUMPTION: PRESSURE SENSOR ACCURACY OF $\pm 5\%$ FSO

FIGURE 4.11-4
NITROGEN-HYDROGEN
PRESSURE CONTROL BANDS

power to the normally open solenoid valve (Item 053) located between the hydrogen and nitrogen circuit.

Feed water is provided to the SPE OGA from the facility through a normally closed solenoid valve (Item 081-1). Operation of this valve is controlled by the water level in the two feed water metal bellows accumulators (Items 605-1 and 605-2) and the position of the four-way ball valve between the two tanks (Item 003). The feed water is polished with a deionizer bed (Item 295) to ensure the water is free of any ionic contamination (cation and anion) that would be detrimental to cell life. A conductivity sensor (Item 755) located immediately downstream of the deionizer bed monitors water quality and performance of the deionizer bed and initiates a shutdown should the water conductivity exceed a specified value.

A listing of the parts used in the SPE Oxygen Generator Assembly processing package is included as Table 4.11-I.

4.12 System Operation

The SPE OGA is designed to accept control commands via the CDU or other suitable device. The operating modes available for the system include IMMEDIATE SHUTDOWN, OFF, ON, STANDBY, and MANUAL. Additional information concerning these modes of operation is provided in the Operations Manual.

Prior to starting the unit, the user should enter the oxygen production requirement and the LIGHT/DARK side duty cycle from the Modify/View Operation screen. If the OGA is to be operated in a cyclic manner, then the user must also select PERIODIC oxygen delivery from the Assembly Configuration screen. Once these tasks are completed, the user can then access the Mode Select screen and select the ON mode. The system will then transition to the ON mode PURGE state. The water recirculation pump (Item 463) is turned on, the nitrogen inlet solenoid valve (Item 051A) is opened and power is applied to the electrochemical hydrogen pumps in the hydrogen-water phase separator.

**TABLE 4.11-I
SPE OXYGEN GENERATOR ASSEMBLY
PARTS LIST**

ITEM NUMBER	ITEM DESCRIPTION	HSD PART NUMBER	VENDOR	VENDOR PART NUMBER
003	Ball valve, 4-way	SVSK115470-2	Flodyne	3J45
005	Solenoid valve, 3-way	SVSK115359-1	Flodyne	2A3572S
051	Solenoid valve, N.C.	SVSK120803-1	Flodyne	2A1504S
051A	Solenoid valve, N.C.	None	Skinner	71215SN1GN00N0H111P3
053	Solenoid valve, N.O.	SVSK120803-2	Flodyne	2A1505S
080-1	Shut-off valve	SVSK115406-3	Whitey	SS-14DKS4
080-2	Shut-off valve	SVSK115406-3	Whitey	SS-14DKS4
080-3	Shut-off valve	None	Nupro	SS-4P4T
080A	Shut-off valve	None	Nupro	SS-4P4T4
081-1	Solenoid valve, N.C.	SVSK115466-2	Flodyne	2J17
081-2	Solenoid valve, N.C.	SVSK115466-2	Flodyne	2J17
081A	Sample valve	None	Nupro	SS-4LA
104-1	Check valve	SVSK114347-1	Autoflow	291900-1
104-2	Check valve	SVSK114347-1	Autoflow	291900-1
105-1	Check valve	None	Nupro	SS-CHS4-1/3
105-2	Check valve	None	Nupro	SS-CHS4-1/3
105-3	Check valve	None	Nupro	SS-CHS4-1/3
120	Differential back pressure regulator	SVSK115351-3	Autoflow	DR6104-514
125	Relief valve	SVSK115354-1	Flodyne	2A260RL
126A	Relief valve	None	Nupro	SS-CHS4-5
127	Differential back pressure regulator	SVSK115351-4	Autoflow	DR6104-516
130	Differential back pressure regulator	SVSK115351-5	Autoflow	DR6104-517
163	Relief valve	None	Nupro	SS-RL3S4
167-1 thru -7	Sample valve	None	Whitey	SS-14DKS4

**TABLE 4.11-I
SPE OXYGEN GENERATOR ASSEMBLY
PARTS LIST**

ITEM NUMBER	ITEM DESCRIPTION	HSD PART NUMBER	VENDOR	VENDOR PART NUMBER
250	Filter	SVSK114340-1	Nupro	SS-4FW-15
295	Deionizer bed	SVSK116644-1	HSD	SVSK116644-1
463	Recirculation pump	SVSK116585-1	Micropump	81492 025
464	Feed water pump	SVSK116585-2	Micropump	E7585 059
554A	Heat exchanger	None	Exergy	00463
605-1	Metal bellows accumulator	SVSK116033-1	Westport Dev	130118
605-2	Metal bellows accumulator	SVSK116033-1	Westport Dev	130118
606	Metal bellows accumulator	SVSK116035-1	Westport Dev	130119
611	Nitrogen accumulator	None	Whitey	316L-HDF4-500
7061	Pressure sensor	None	Druck	PDCR130/W/C-0520
7062	Pressure sensor	SVSK117247-5	Druck	PDCR130/W/C
7063	Pressure sensor	None	Druck	PDCR130/W/C
708	Differential pressure sensor	SVSK117248-3	Sensotec	Model 060
709	Differential pressure sensor	SVSK117247- 10	Druck	PDCR130/70WL/C
736-1	Temperature sensor	SVSK111142-2	RdF	21637
736-2	Temperature sensor	SVSK111142-2	RdF	21637
745	Flow switch	None	efector	STN12ABBE1/S
746-1	Combustible gas sensor	SVSK115299-1	General Monitors	SC100
746-2	Combustible gas sensor	SVSK115299-1	General Monitors	SC100
746-3	Combustible gas sensor	None	General Monitors	10058-1
746-4	Combustible gas sensor	None	General Monitors	10058-1
749	Pressure sensor	SVSK119328-1	Kulite	IPTE-51-1000-100D

**TABLE 4.11-I
SPE OXYGEN GENERATOR ASSEMBLY
PARTS LIST**

ITEM NUMBER	ITEM DESCRIPTION	HSD PART NUMBER	VENDOR	VENDOR PART NUMBER
755	Conductivity sensor	SVSK118458-1	Sensor Development	CS1042-0.1-HS-SAE-HP
762-1	Temperature sensor	SVSK111142-3	RdF	21628
762-2	Temperature sensor	SVSK111142-3	RdF	21628
812A	Flow restrictor	None	Lee Co.	VDLA4326565H
906	Electrolysis module	SVSK116112-1	HSD	SVSK116112-1
907	Oxygen phase separator	SVSK116112- 101	HSD	SVSK116112-101
908	Hydrogen phase separator	SVSK116112- 102	HSD	SVSK116112-102

After successfully completing a purge of the hydrogen circuit, the nitrogen purge valve, Item 053, is energized closed and the nitrogen reference system begins to pressurize. Once the nitrogen pressure reaches 50 psia, the system will transition from the PURGE state to the PROCESS-VENT state, where current to the electrolysis cell stack is ramped to approximately 26 amps, the current level required to produce oxygen on a continuous basis at the rate of 7.4 lb_m/day. Oxygen gas will be delivered to the oxygen outlet interface, while a mixture of nitrogen and hydrogen will be delivered to the hydrogen vent interface. At this time the bellows control laws are active; should the water level in the water recirculation loop metal bellows accumulator fall below a predetermined value, the feed pump (Item 464) will be energized to draw water from either of the two feed water bellows tanks. Feed water from the facility is introduced whenever the level in the feed tank falls below a preset level and the four-way ball valve is in a particular position. Detailed information regarding the operation of the metals bellows accumulators and associated hardware is available in the Process Controller Software Requirements Specification.

Once the hydrogen circuit has been sufficiently purged of nitrogen, the system enters the PROCESS state. Once in the PROCESS state, the current to the electrolysis cell stack is set to a level based on the user inputs for oxygen production and LIGHT/DARK side requirements. In addition, the three-way solenoid valve (Item 005) switches the flow of hydrogen from the vent interface to the outlet interface provided the user has selected REDUCTION for hydrogen delivery (refer to the Operations Manual). The system will remain in the PROCESS state until either the user changes modes, or a system fault is detected. If PERIODIC oxygen delivery was selected, the current to the electrolysis cell stack is reduced to a trickle value of 1 amp once the LIGHT side of the simulated orbit has been completed. The current remains at 1 amp for the duration of the DARK side, and is sufficiently high enough to maintain polarization of the electrolysis cells and to prevent decay in the hydrogen pressure. During the DARK side, the water recirculation pump remains on, the bellows level control laws remain active, and all system instrumentation continues to monitor system health. Once the DARK side of the simulated orbit has been completed, the preset current

level is restored to the electrolysis cell stack and full oxygen production returns.

If the user had selected the STANDBY mode instead of the ON mode, the SPE OGA would transition at the end of the PROCESS-VENT state to the HOLD state rather than to the PROCESS state. The HOLD state places the OGA in a configuration identical to that of the DARK side of the simulated orbit; however, the system will remain in this state until either the user changes modes or a system fault is detected.

Termination of the test can be accomplished during operation in any mode or state within a mode by selecting either the IMMEDIATE SHUTDOWN mode or the OFF mode. If the OFF mode is selected, the system transitions to the RECIRC state. In the RECIRC state, power to all actuated components within the system is removed with the exception of the recirculating water pump. The pump remains on for an additional two minutes to purge the recirculation loop of oxygen. With power removed from the remainder of the actuated components, a nitrogen purge and corresponding depressurization of the hydrogen circuit occurs. The IMMEDIATE SHUTDOWN mode removes power to all actuated components, including the recirculating water pump, and should therefore be used only in the event of an emergency shutdown.

A nitrogen purge and subsequent depressurization of the hydrogen circuit is accomplished once power is removed from the purge valve, Item 053. Should the purge valve fail to open during the shutdown, the emergency depressurization valve (Item 051) is opened and, when the nitrogen-hydrogen differential pressure exceeds 45 psid, the nitrogen-hydrogen relief valve (Item 125) opens to purge and safely depressurize the hydrogen circuit.

5.0 SYSTEM TESTING

The refurbished SPE Oxygen Generator Assembly was subjected to an acceptance test program as defined in the Master Test Plan contained in Appendix B. The purpose of the acceptance test program was to verify the effectiveness of the refurbishment by demonstrating elimination of operational deficiencies present in the original system, and operation of the system at various oxygen generation rates and in a cyclical manner. After successfully completing a thorough check-out test, including proof pressure and leakage testing, anomaly verification testing and mode/state transition testing, the unit operated for 743 hours, including 693 hours in the cyclic mode of operation. With a simulated orbit of 90 minutes, the system completed approximately 460 cycles of light side/dark side operation. Power requirements of the different components in the system were recorded in Appendix A of the test plan, and flow measurements at different operating conditions were made and recorded in Appendix B of the test plan. The gas quality of the product gases was also determined through standard laboratory analytical techniques, with the results indicating no cross contamination of one gas with the other at the detection level of the instrument (see Appendix C of the test plan). Specific test results and findings are detailed in the following sections.

5.1 Electrolysis Cell Stack Performance

The electrolysis module, consisting of 18 SPE electrolysis cells, was assembled and successfully completed its check-out tests in January 1995. The module was then placed in a separate test rig to conduct performance testing as defined in the test plan. However, the average cell potential for the module at 90°F was 1.884 Vdc, over 100 mV higher than expected. Chemical analyses of the effluent from the module, in conjunction with other analytical techniques, revealed that the stack had been contaminated with a sodium salt from the test rig. The contamination of the rig likely occurred while moving the rig from the test facility in Building 20B to the new facility in Building 2. A decision was made to disassemble the module and replace the membrane and electrode assemblies. The cell mechanical hardware, as well

as the test rig, were cleaned and subjected to numerous rinses with fresh DI water. In addition, a single cell was assembled and placed on test to verify the cleanliness of the test rig. A new module was assembled and subsequently placed on test. The average cell potential was 1.751 Vdc for the 100+ hour run, approximately 130 mV better than the initial build. Figure 5.1-1 displays the average cell potential for electrolysis module build-up #1 and #2.

Performance of the 18-cell stack operating in complete SPE OGA is presented in Figure 5.1-2 as average cell potential versus OGA operating time. Average cell potential is approximately 1.80 Vdc for the first 50 hours of operation, where the OGA was producing 7.4 lb_m/day of oxygen on a continual basis. Cyclic testing of the system began at approximately the 50 hour mark, with the cell stack producing the requisite amount of oxygen at a 60% duty cycle (54 minutes on / 36 minutes off). The average cell potential at 70°F varies between approximately 1.85 Vdc when the stack is at its required load, to approximately 1.55 Vdc when the stack is at its standby level of 1 amp. At approximately the 120 hour mark, the oxygen requirement was increased to 8.14 lb_m/day, decreased to 6.66 lb_m/day, increased to 8.14 lb_m/day, and finally returned to 7.4 lb_m/day. The oxygen and hydrogen flow rates were measured and verified to be correct with a wet test meter as described in the master test plan. At approximately the 140 hour mark, the duty cycle was changed to 66% (60 minutes on / 30 minutes off) to verify proper generation rates at an off design duty cycle. The duty cycle was changed to 53 minutes on / 37 minutes off just prior to the 480 hour mark in the test program when it was realized the space station orbit of 54 minutes on / 36 minutes off was no longer valid.

The average cell performance was stable throughout the entire test program. In particular, when the deionizer bed was removed from the recirculating water loop due to flow anomalies to be discussed in a later section, there was no discernible difference in the average cell potential.

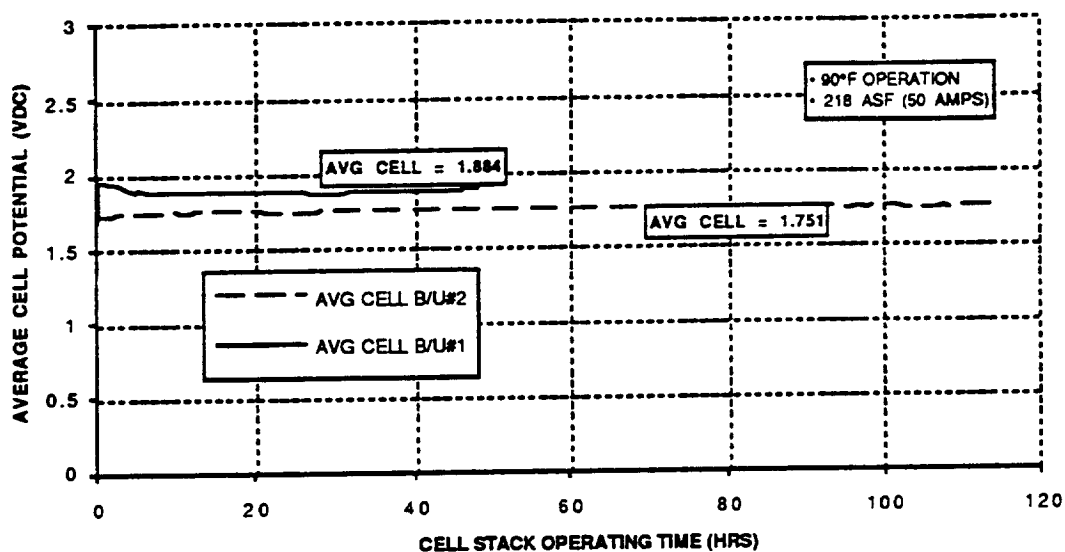


FIGURE 5.1-1
18-CELL ELECTROLYSIS CELL STACK
PERFORMANCE COMPARISON

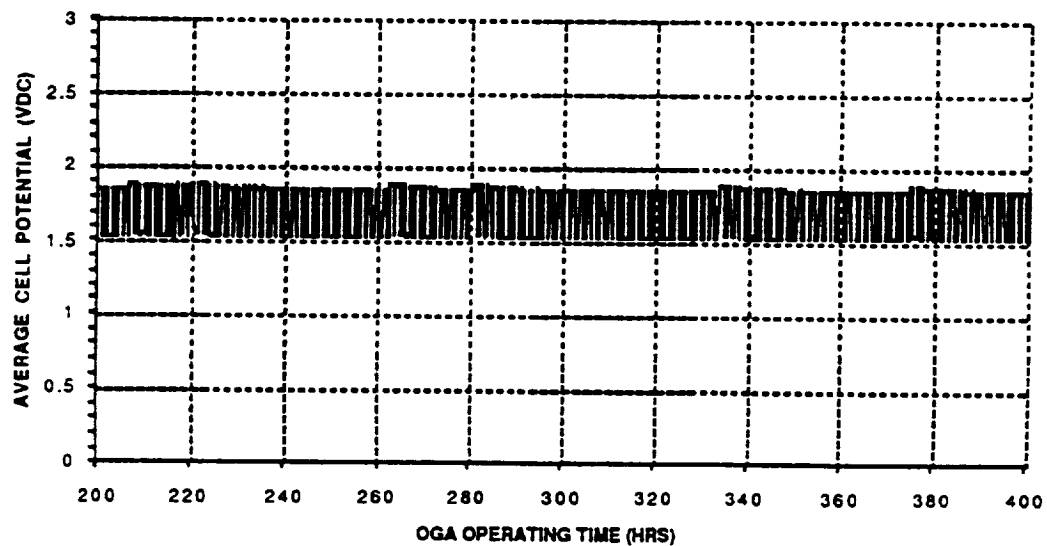
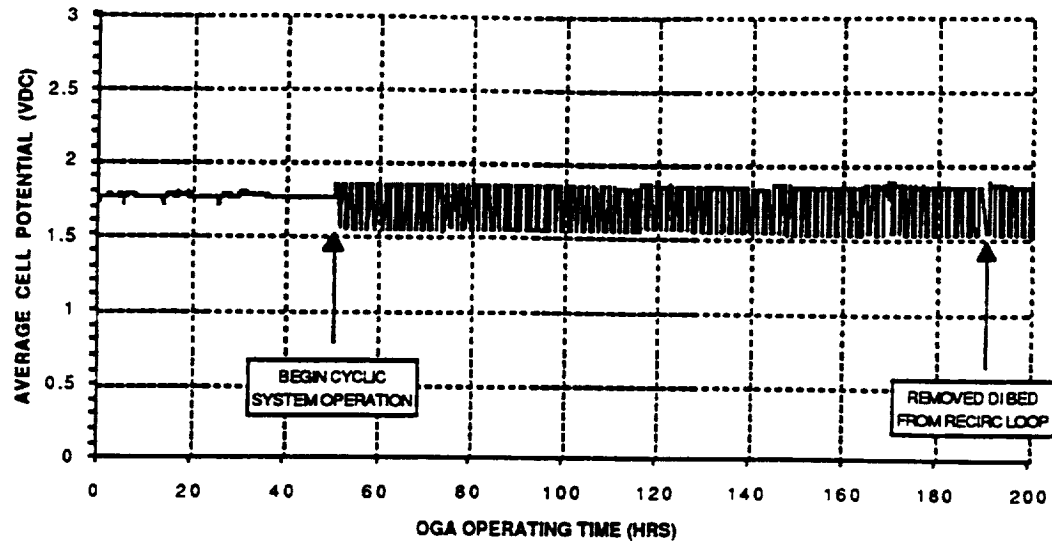


FIGURE 5.1-2
SPE OGA
AVERAGE CELL POTENTIAL

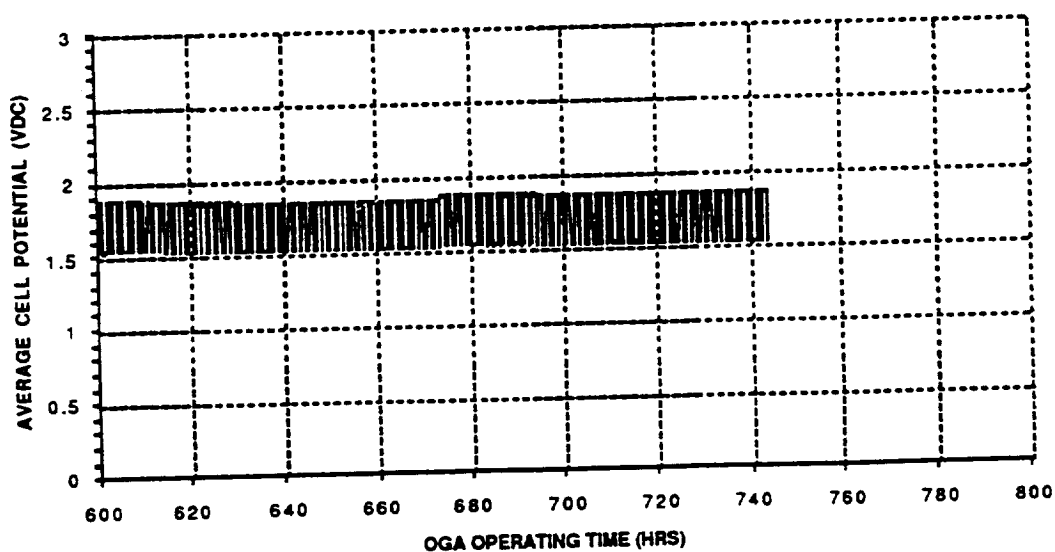
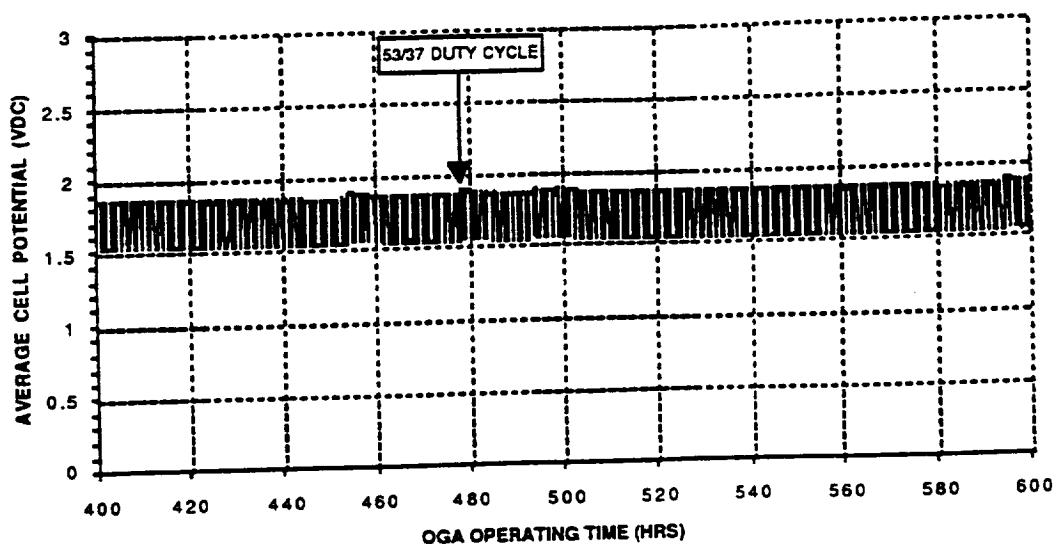


FIGURE 5.1-2 (CONT'D)
SPE OGA
AVERAGE CELL POTENTIAL

The oxygen and hydrogen production rates are plotted in Figures 5.1-3 and 5.1-4, respectively, and are a measure of the instantaneous production rates of the OGA. For example, in order to provide the nominal daily requirement of 7.4 lb_m/day at a 60% duty cycle, the instantaneous oxygen production rate would have to be 12.33 lb_m/day, as depicted in the plots. As stated earlier, the oxygen and hydrogen flow rates were verified correct at the minimum, nominal and maximum oxygen requirement.

Current to the electrolysis cell stack is presented as Figure 5.1-5. The plot of current vs. time mimics those of the gas production rates since the latter are a direct function of the former. The standby current level for the system from hour mark 50 to 145 was 2 amps; however, this level was reduced to 1 amp when testing revealed the electrolysis power supplies could be adequately controlled at such a low current level.

5.2 Recirculating Water Loop Performance

One of the key reasons for refurbishing the LFSPE oxygen generation subsystem was its inability to adequately prime during system start-up. The original system employed a water purging technique at system start-up in order to purge the loop of oxygen that had come out of solution during system depressurization. However, the purge typically lasted 30 minutes or longer and was only about 50% effective in priming of the recirculation water pump. The refurbished SPE OGA eliminated this pump priming problem by: reducing the loop operating pressure; maintaining the pump inlet above ambient pressure during all aspects of system operation; and, repackaging the system to minimize potential 1-g gas traps. As part of the acceptance test program, the SPE OGA was subjected to a number of powered and unpowered shutdowns to determine the effectiveness of the system changes to allow proper operation of the recirculation pump during system start-up. After each system shutdown and restart, the pump was able to prime and begin recirculating water through the system in only a matter of a few seconds.

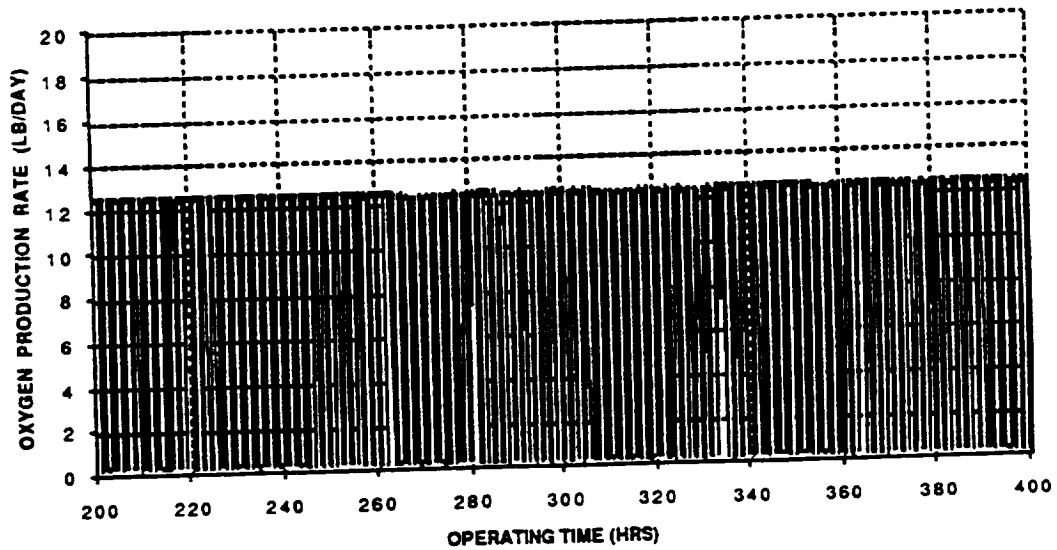
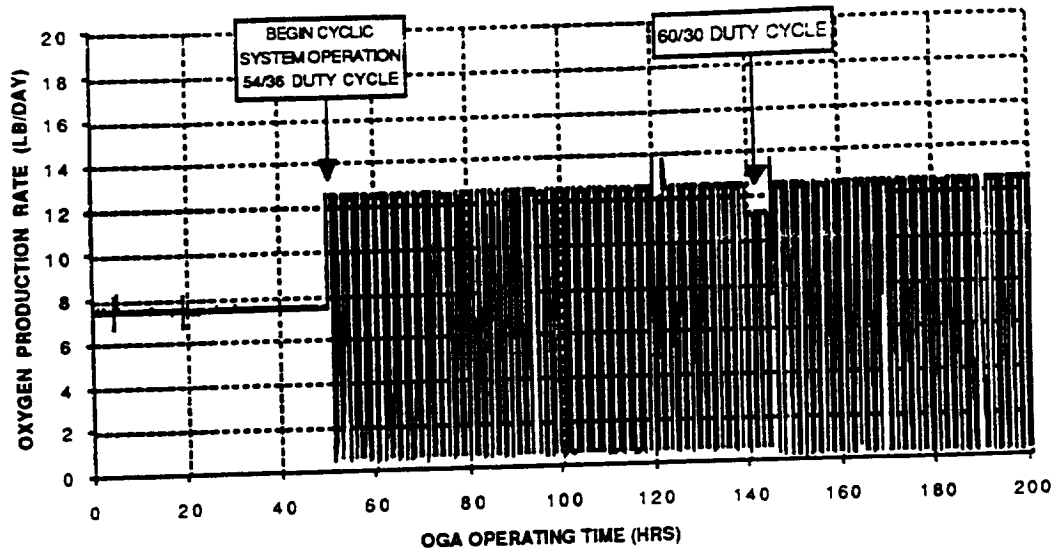


FIGURE 5.1-3
SPE OGA
OXYGEN PRODUCTION RATE

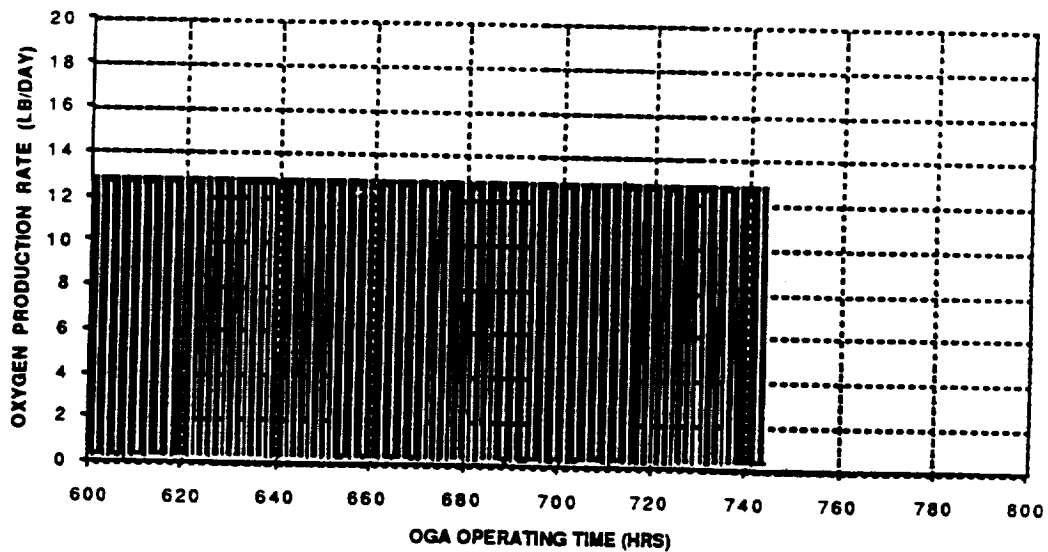
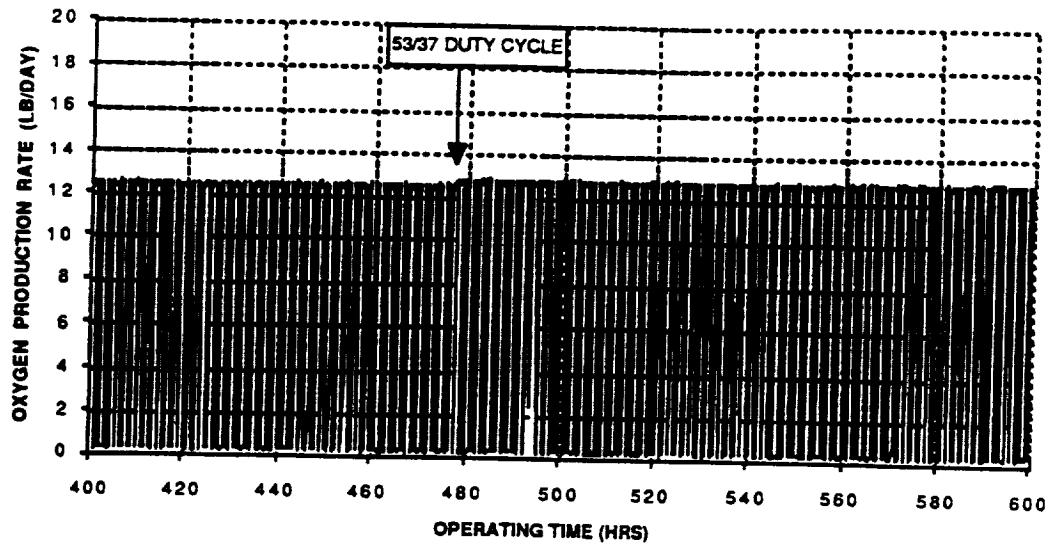


FIGURE 5.1-3 (CONT'D)
SPE OGA
OXYGEN PRODUCTION RATE

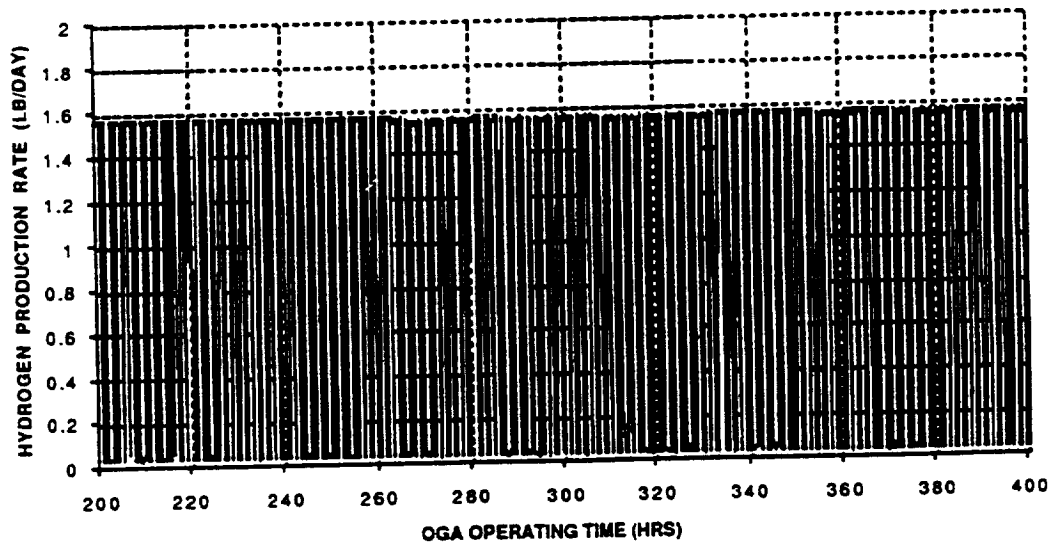
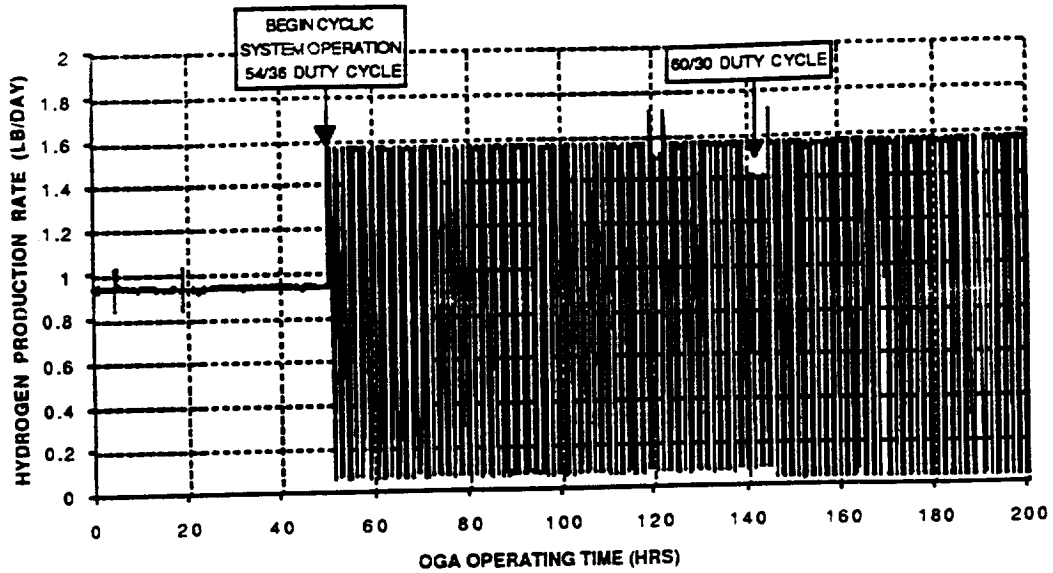


FIGURE 5.1-4
SPE OGA
HYDROGEN PRODUCTION RATE

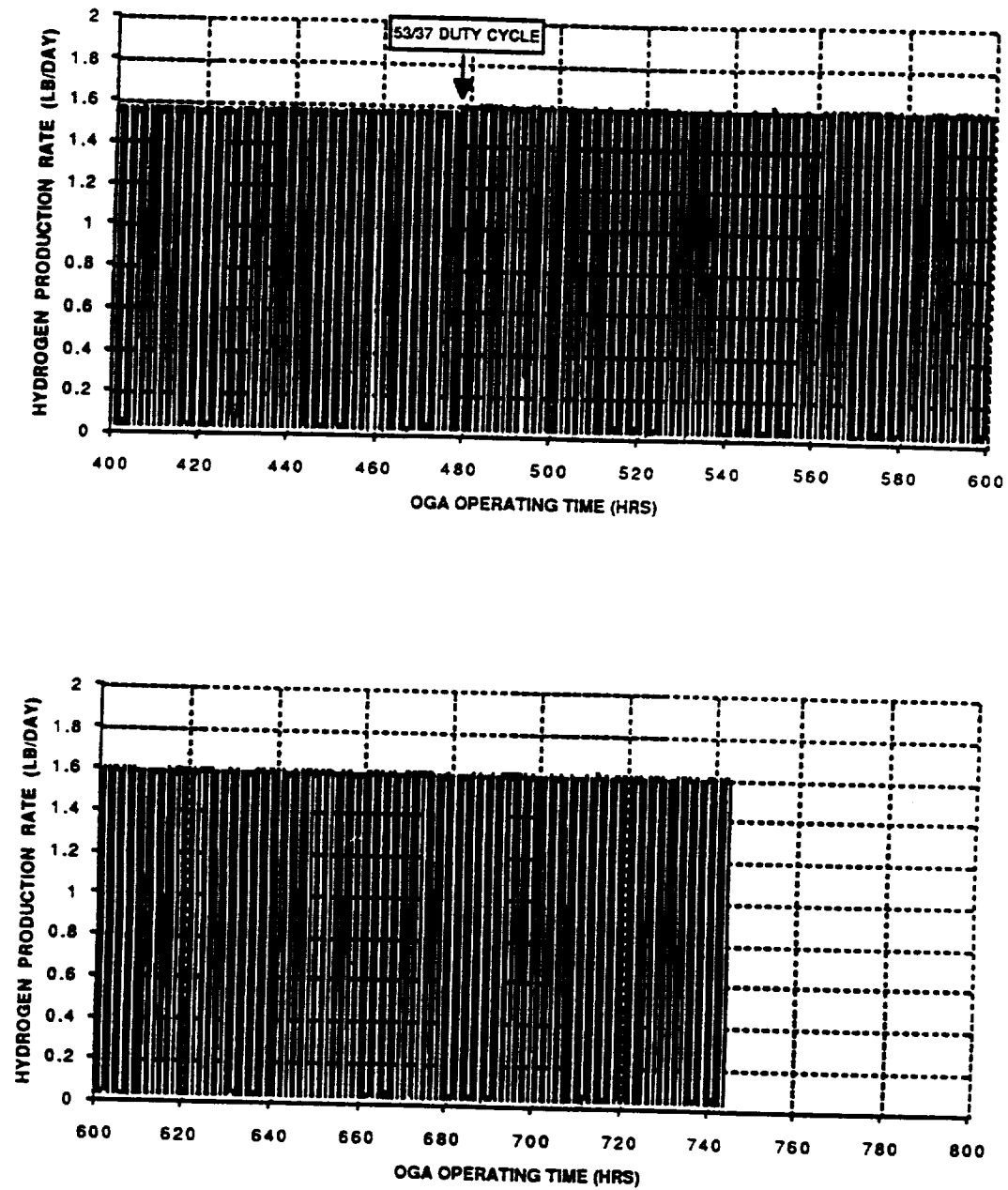


FIGURE 5.1-4 (CONT'D)
SPE OGA
HYDROGEN PRODUCTION RATE

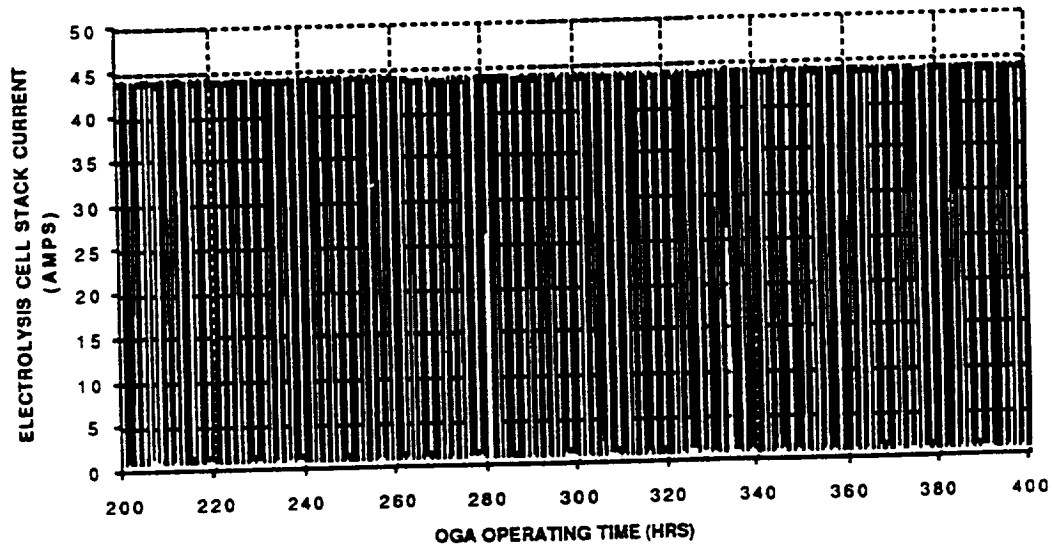
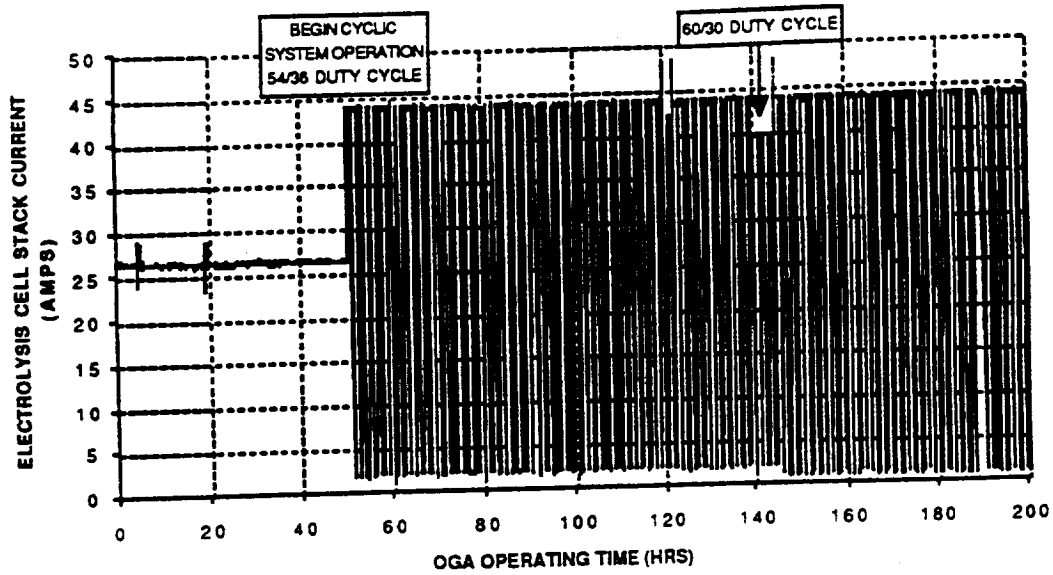


FIGURE 5.1-5
SPE OGA
ELECTROLYSIS CELL STACK CURRENT

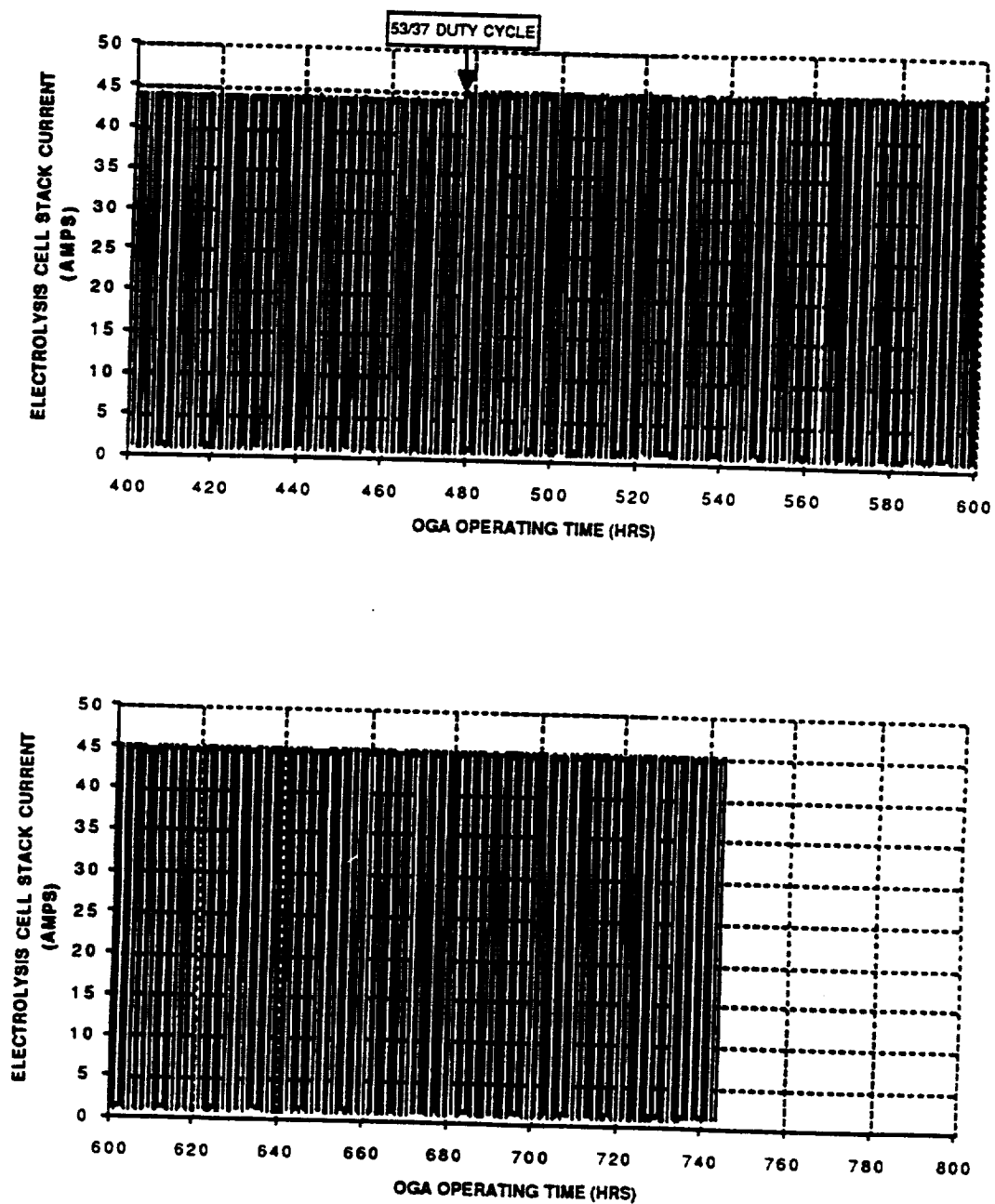


FIGURE 5.1-5 (CONT'D)
SPE OGA
ELECTROLYSIS CELL STACK CURRENT

Additional changes to the recirculating water loop included modifying the bellows accumulator level sensor, incorporating a liquid to liquid heat exchanger, and replacing the pressure sensor used to calculate a water flow rate with a thermal flow switch. The bellows accumulator level sensor was modified from seven discrete switch points to an analog device, allowing the controller and the operator to know more accurately the level within the accumulator at all times. The liquid to liquid heat exchanger, as mentioned earlier, maintains the correct operating temperature of the recirculating water loop even with all 18 cells operating at a cell potential of 2.5 Vdc. The flow switch monitors the flow rate to the module, and initiates a system shutdown if a low flow condition occurs.

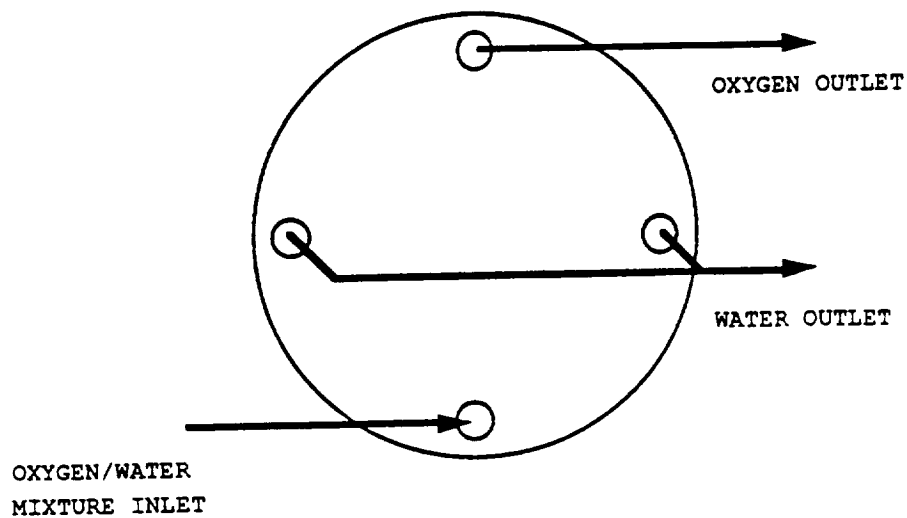
During the first half of the test program the flow switch registered a number of low water flow conditions, sometimes resulting in a shutdown of the system. A low flow shutdown is triggered by the system controller if the recirculating water flow rate is below the flow switch setpoint for 10 seconds. The calibration of the flow switch was checked a number of times and was found to be correct on all occasions. The speed of the motor, and hence the water flow rate, was increased incrementally from 0.48 GPM to 0.60 GPM to determine if higher flow rates would prevent the shutdown from occurring. However, a number of low flow conditions were recorded after the pump speed was set at the 0.60 GPM setting.

A number of actions were taken with respect to the recirculation water loop hardware in an attempt to resolve the low flow condition. At the 190 hour mark, the deionizer bed was removed from the recirculation loop. The bed was removed since, due to its high pressure drop, it was a source for dissolved oxygen to come out of solution and, because of its geometry, it acted as a 1-g gas trap. The theory was that the gas bubbles which collected in the bed housing would cause channeling in the resin bed, resulting in even higher pressure drops. Eventually, sufficient gas would collect in the bed housing to cause the pump to stall. Or, the bubbles would escape the bed and migrate to the flow switch, causing it to trigger a loss of flow condition. The system was returned to test; however, the occasional low flow condition persisted.

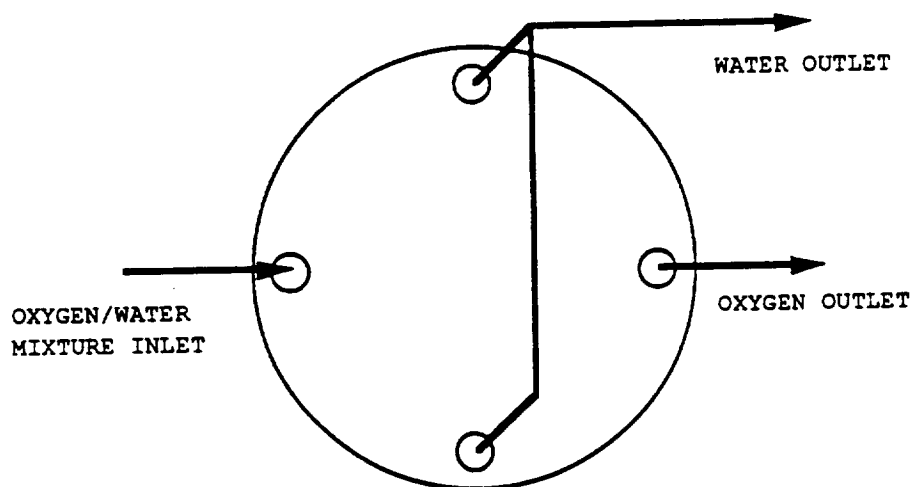
At the 215 hour mark, the oxygen phase separator was rotated 90° since, after further reviewing the package assembly, it was deemed to act as a 1-g gas trap. Figure 5.2-1 depicts the orientation of the phase separator before and after the rotation. As the oxygen-saturated water flows through the hydrophilic membrane of the phase separator assembly, some of the oxygen comes out of solution as tiny gas bubbles. The original orientation of the phase separator had the water outlets at the 3 and 9 o'clock positions, allowing the bubbles to coalesce and collect in the top half of the water cavities of the assembly. Changes in the operating pressure or temperature of the phase separator assembly could cause the gas bubble at the top of these cavities to expand, resulting in a substantial quantity of gas becoming entrained in the water outlet ports. The gas would flow to the bellows accumulator and finally to the pump inlet, resulting in cavitation of the pump. Hence, the phase separator assembly was rotated 90° such that the water outlets were at the 6 and 12 o'clock positions. In this manner, oxygen bubbles evolving from solution would be swept out of the water cavity in a more uniform manner, rather than as potential slugs of gas. The system was returned to test, but still occasional low flow conditions occurred.

At approximately the 265 hour mark, the OGA was shutdown, and the following actions were undertaken to determine the cause for the occasional low flow condition:

- A strip chart recorder was installed to monitor the output signal from the flow sensor, and the input signals to the two motor controllers that drive the brushless DC motors on the recirculating water pump and the feed water pump.
- A rotameter was installed at the pump outlet to visually monitor the flow rate of the recirculating water loop. The rotameter was installed in the loop using 3/8" O.D. PFA tubing.
- The 3/8" O.D. stainless steel tubing connecting the water output from the phase separator to the bellows accumulator inlet, and that connecting the bellows accumulator outlet to the pump inlet were



ORIGINAL PHASE SEPARATOR ORIENTATION



FINAL PHASE SEPARATOR ORIENTATION

FIGURE 5.2-1
OXYGEN PHASE SEPARATOR
ASSEMBLY ORIENTATION

replaced with translucent PFA tubing. A video camera was installed in the test facility to monitor the water quality exiting the phase separator-entering the bellows accumulator and exiting the bellows accumulator-entering the pump inlet.

The system was returned to test and, as expected, it was observed that the oxygen phase separator water outlet occasionally released a stream of small gas bubbles into the water outlet. However, it was also observed that the bubbles entering the bellows accumulator tended to coalesce, resulting in larger bubbles exiting the accumulator and entering the pump inlet. A review of the bellows accumulator geometry revealed that the port connections of the tank were below the dome of the accumulator such that it became a 1-g gas trap.

On the morning of May 23, at the 322 hour mark, a low flow condition was registered on the strip chart recorder. The duration of the low flow condition was approximately 8 seconds, 2 seconds short of triggering an alarm condition. A review of the video tape revealed that a fairly large stream of bubbles exited the phase separator and were deposited into the bellows accumulator. A second stream of bubbles emerged from the separator and entered the accumulator, followed by a large stream exiting the accumulator. The pump immediately became gas bound and the flow of water ceased. A large bubble was trapped directly at the pump inlet and at the exit of the bellows accumulator. During the 8 second period, the pump was able to "consume" the bubble, and flow was reestablished.

In order to prevent the bellows accumulator from behaving as a 1-g gas trap, the plumbing to it was modified such that the flow of water went directly from the phase separator outlet to the pump inlet, with the bellows accumulator connected to the recirculating water pump on the run of a union tee. In this manner the bellows still functions as an expansion volume during cell stack current changes and as a batch feed tank for the electrolysis process. The system was run for approximately 144 hours without indication of a loss of flow condition. At approximately the 475 hour mark, the PFA tubing was replaced with stainless steel tubing, and the rotameter was

removed from the recirculating water loop. The SPE OGA continued to operate without a loss of flow condition during the remaining 270 hours of the test program.

Pressure drop across the hydrophilic element of the oxygen phase separator is presented in Figure 5.2-2. The different events that led to changes in the pressure drop are depicted in the text boxes on the graphs. The change that is of most interest, however, is shortly after the rotameter was removed from the system and the PFA tubing was replaced with stainless steel, at the 475 hour mark. When testing was resumed, it was observed that the pressure drop across the hydrophilic element experienced a number of transients, as did the pressure at the cell stack outlet (see Figure 5.2-3). Although the pressure drop was significantly lower than the 36 psid bubble point of the hydrophilic membrane, it was a phenomenon that had not been observed before and therefore required investigation.

While reviewing the test data, it was determined that most of the transient conditions occurred shortly after the feed pump completed introducing water into the recirculation loop. Since the majority of the recirculation water loop resistance is downstream of the feed pump, introduction of an additional volume of water into the loop results in a pressure rise that is eventually dampened once the additional water volume passes through the separator and the normal flow/pressure regime is re-established. The transient was not observed when the rotameter and PFA tubing were in the loop since the volume of water introduced was a smaller percentage of the loop volume upstream of the phase separator. This additional loop volume dampened the pressure transient to essentially zero at the phase separator inlet. In order to reduce the spike of the transient, the feed pump outlet was relocated from immediately upstream of the electrolysis cell stack to immediately downstream of the recirculation pump outlet at the 670 hour mark. In addition, the volume of water introduced by the feed pump was reduced. These two events helped to reduce the frequency and amplitude of the transient conditions. Overall, the performance of the oxygen phase separator was satisfactory through the duration of the test program.

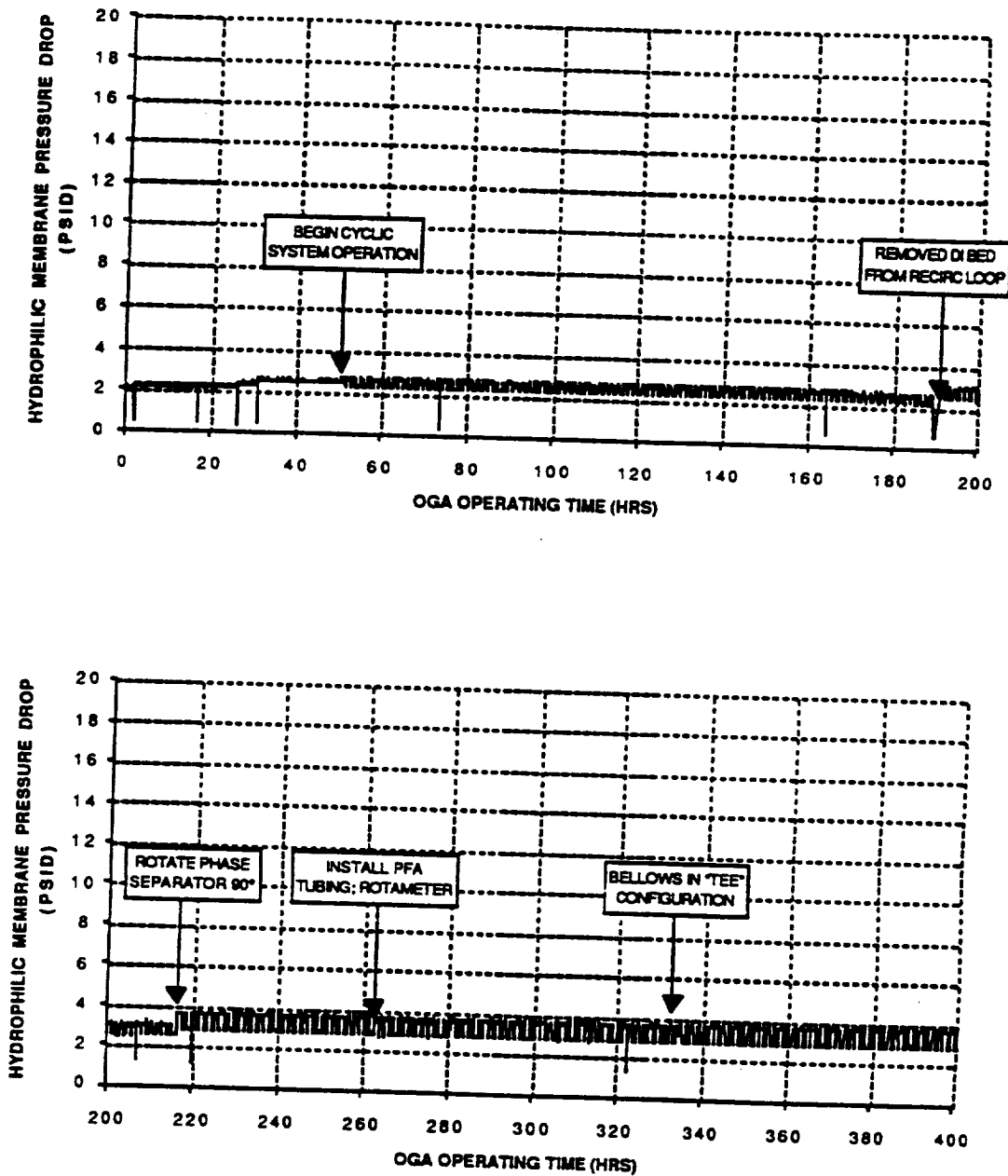


FIGURE 5.2-2
SPE OGA
OXYGEN PHASE SEPARATOR PERFORMANCE

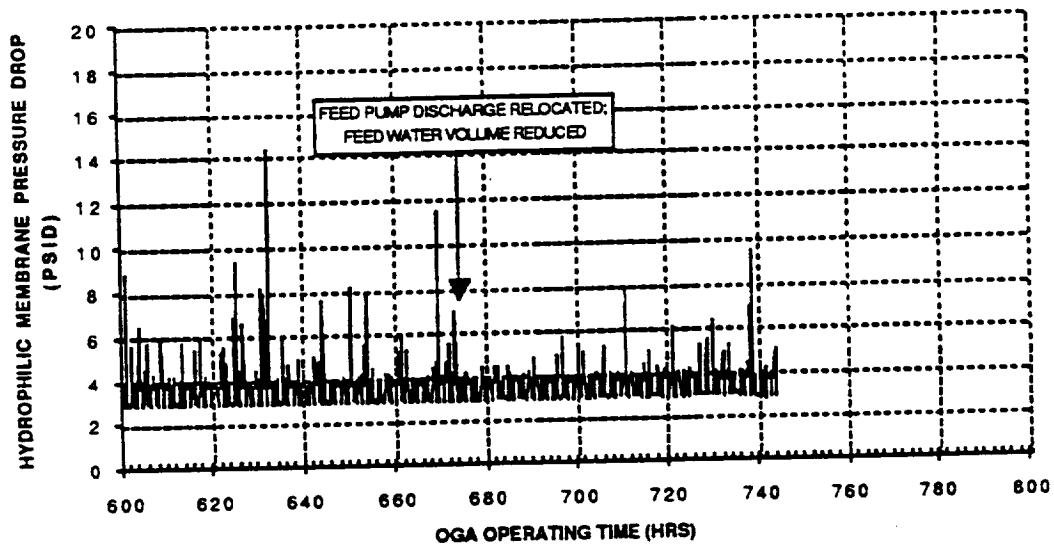
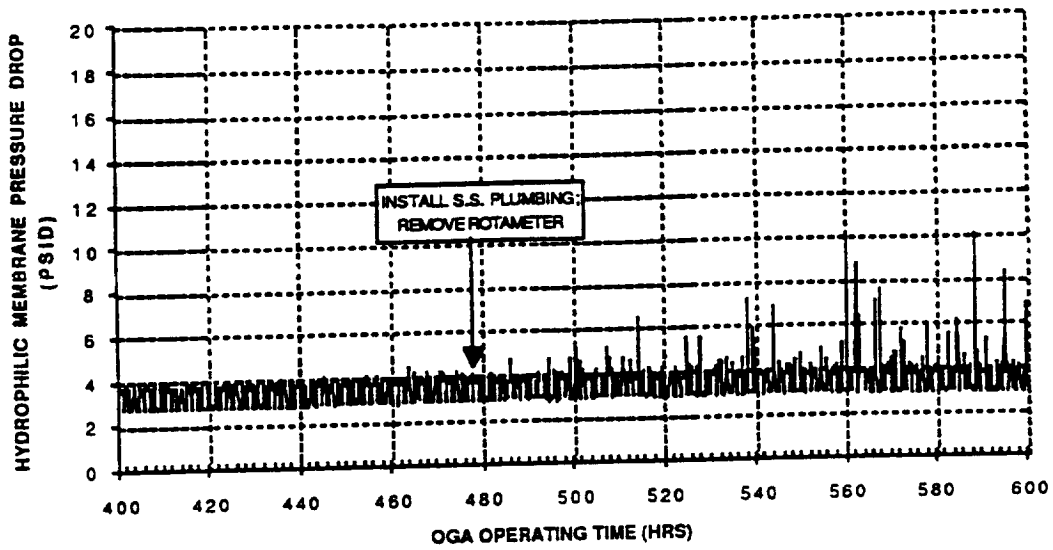


FIGURE 5.2-2 (CONT'D)
SPE OGA
OXYGEN PHASE SEPARATOR PERFORMANCE

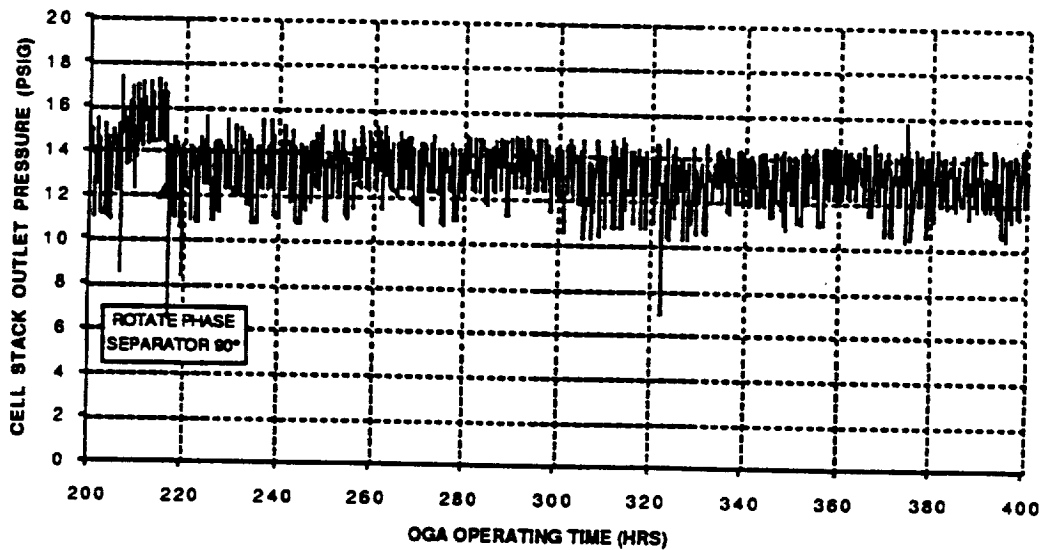
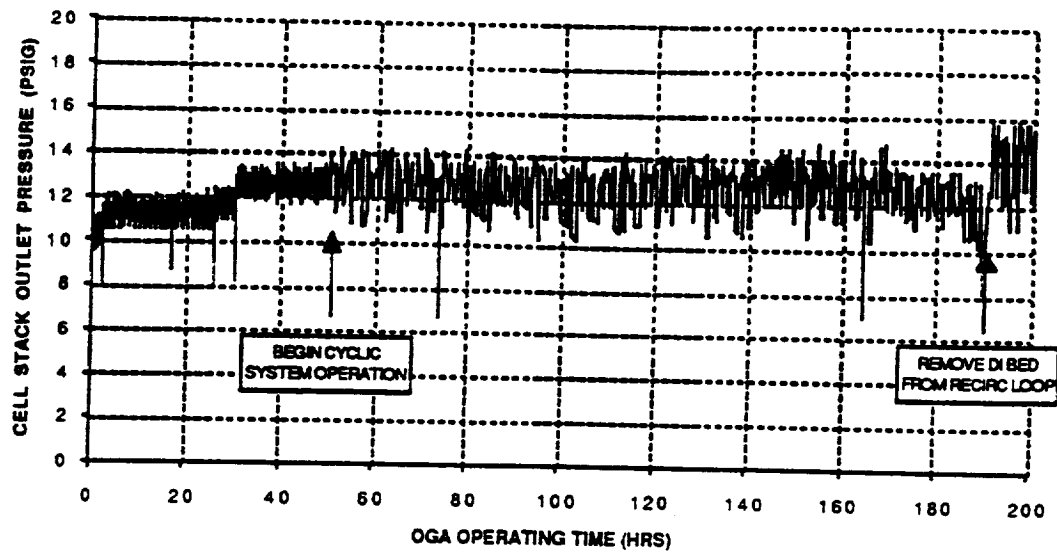


FIGURE 5.2-3
SPE OGA
CELL STACK OUTLET PRESSURE

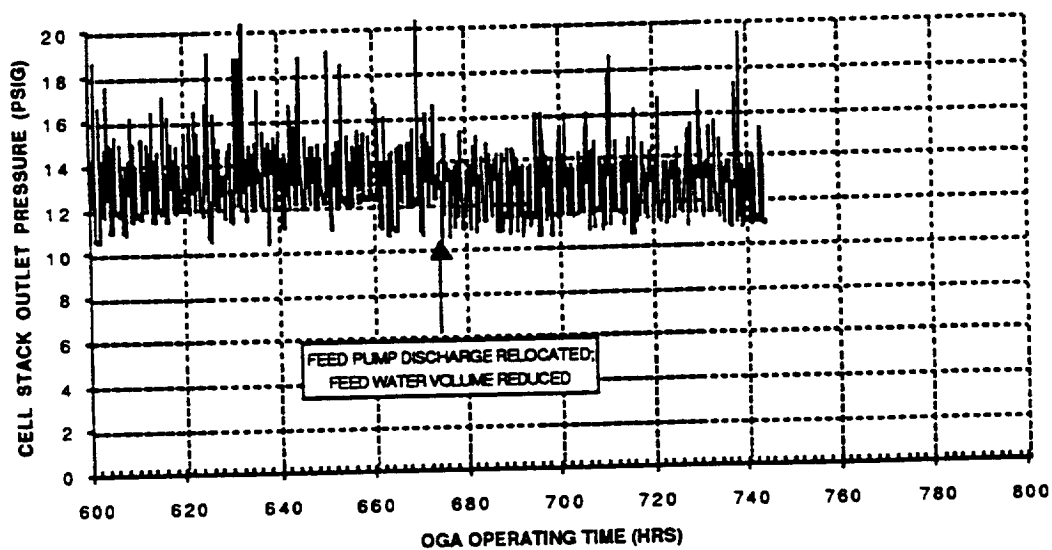
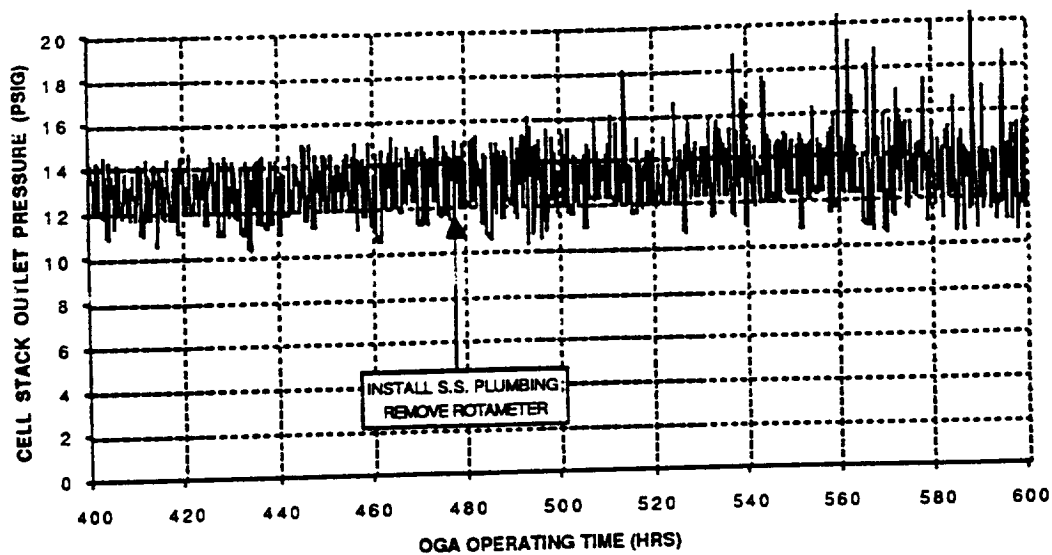


FIGURE 5.2-3 (CONT'D)
SPE OGA
CELL STACK OUTLET PRESSURE

5.3 Hydrogen Phase Separator Performance

As stated earlier, the hydrogen phase separator was revised to include two hydrophilic-hydrophobic cavities rather than a single hydrophilic element, and to eliminate the hydrogen sense cell whose function had been essentially bypassed during the 1990 test program. The performance of the hydrophilic-hydrophobic portion of the refurbished phase separator was satisfactory during the conduct of this test program. The pressure drop across the hydrophilic element is presented as Figure 5.3-1. This separator also experiences transients in hydrophilic membrane differential pressure; however, these transients occur when the system is transitioning from the dark side of the orbit to the light side. When the current to the electrolysis cell stack begins to increase, the hydrogen gas which serves as the reference pressure for the differential back pressure regulator increases in pressure more rapidly than the water at the inlet of the regulator. As a result, the differential pressure measured across the hydrophilic element climbs and remains high until the water pressure can catch up. The length of the transient condition is typically less than 30 seconds, and the differential pressure never exceeds the 36 psid bubble pressure of the hydrophilic membrane. The data plots only show pressure transients centered about the 60 hour mark and the 440 hour mark due to the fact the data is logged to disk only once every 5 minutes, and the duration of the transition is only approximately 30 seconds for each 90 minute cycle.

The electrochemical hydrogen pump performance was satisfactory throughout the duration of the program. However, the circuit which controls current to the cells experienced some problems. Since the electrochemical hydrogen pump cells behave as large capacitors, a special circuit had been designed to control the current to the cells. However, the circuit frequently malfunctioned, resulting in the cells either not charging at all or charging too rapidly. If the cells tried to charge too rapidly, the power supply would go into current limit mode by reducing the voltage to the load. The problem was later traced to an electrical contactor that was in the process of burning out and finally failed closed, resulting in damage to the components in the control circuit. An analysis of the circuit revealed that the power supply sense line

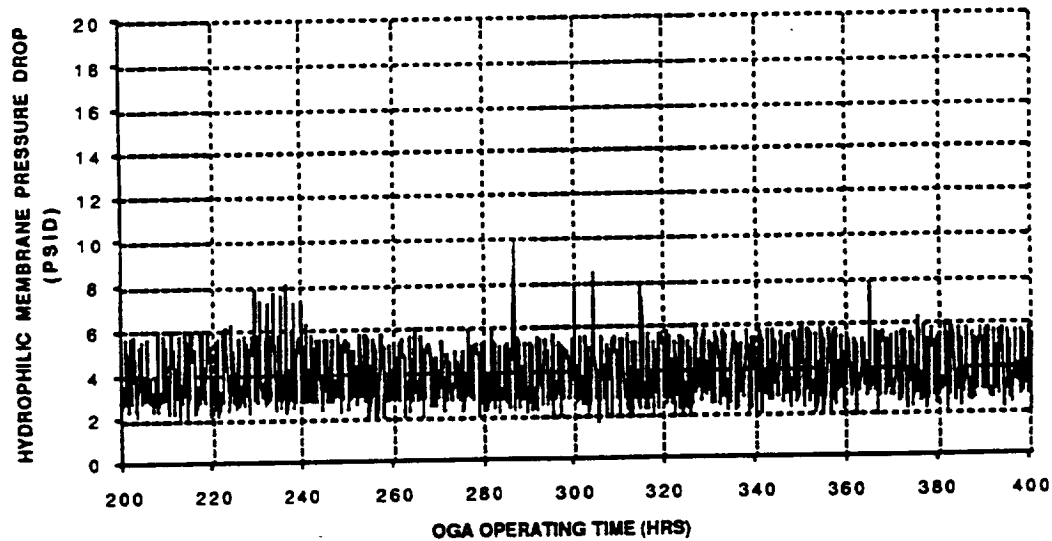
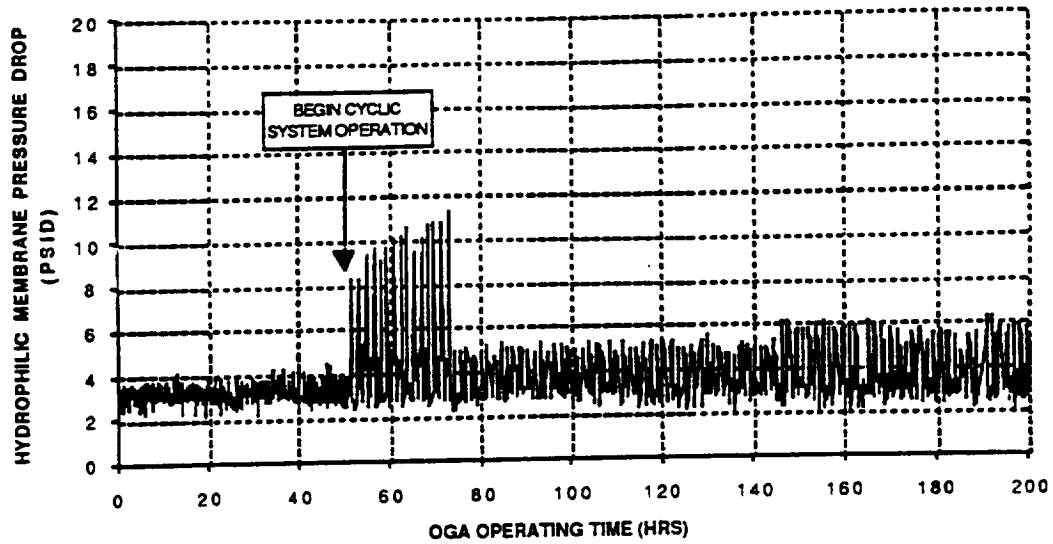


FIGURE 5.3-1
SPE OGA
HYDROGEN PHASE SEPARATOR PERFORMANCE

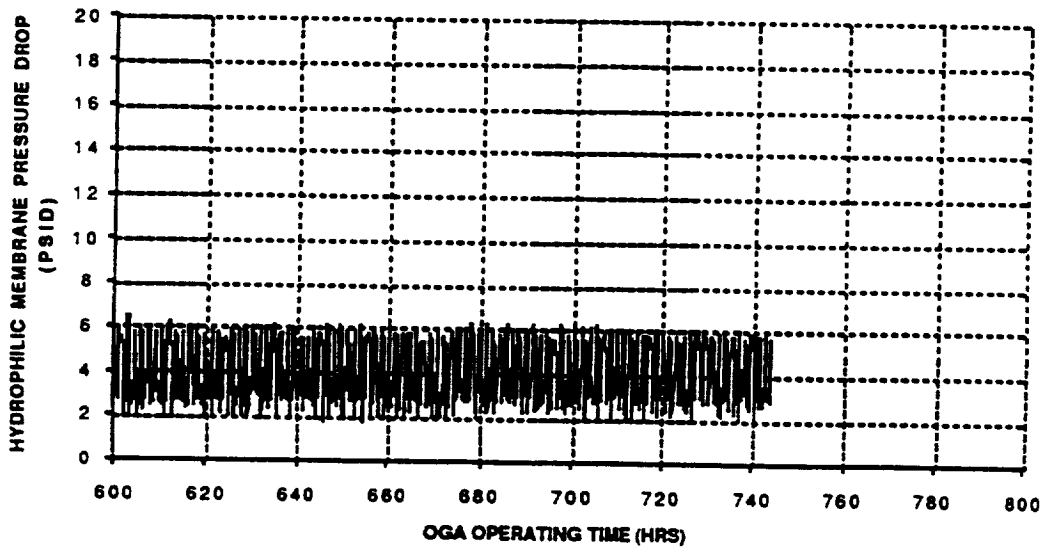
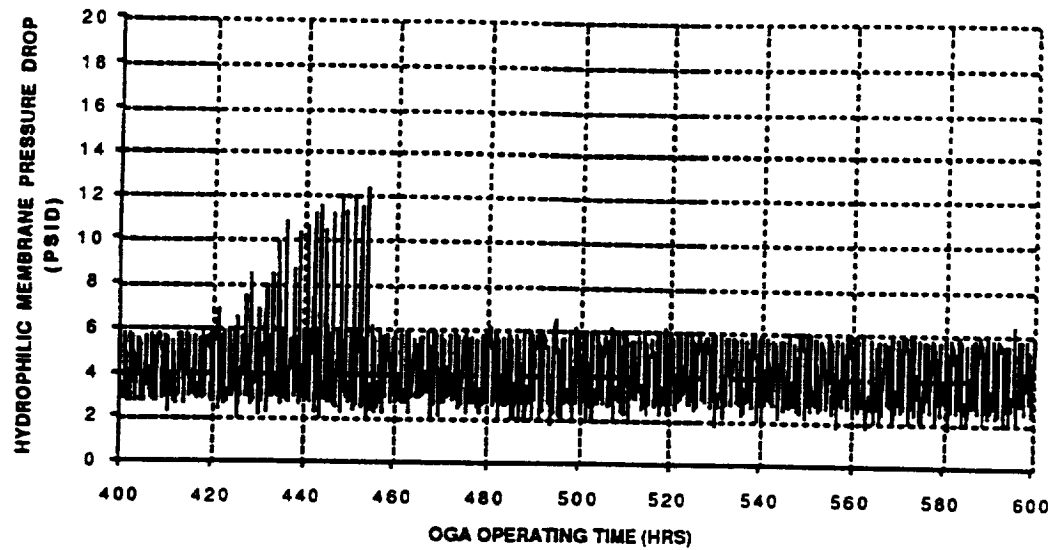
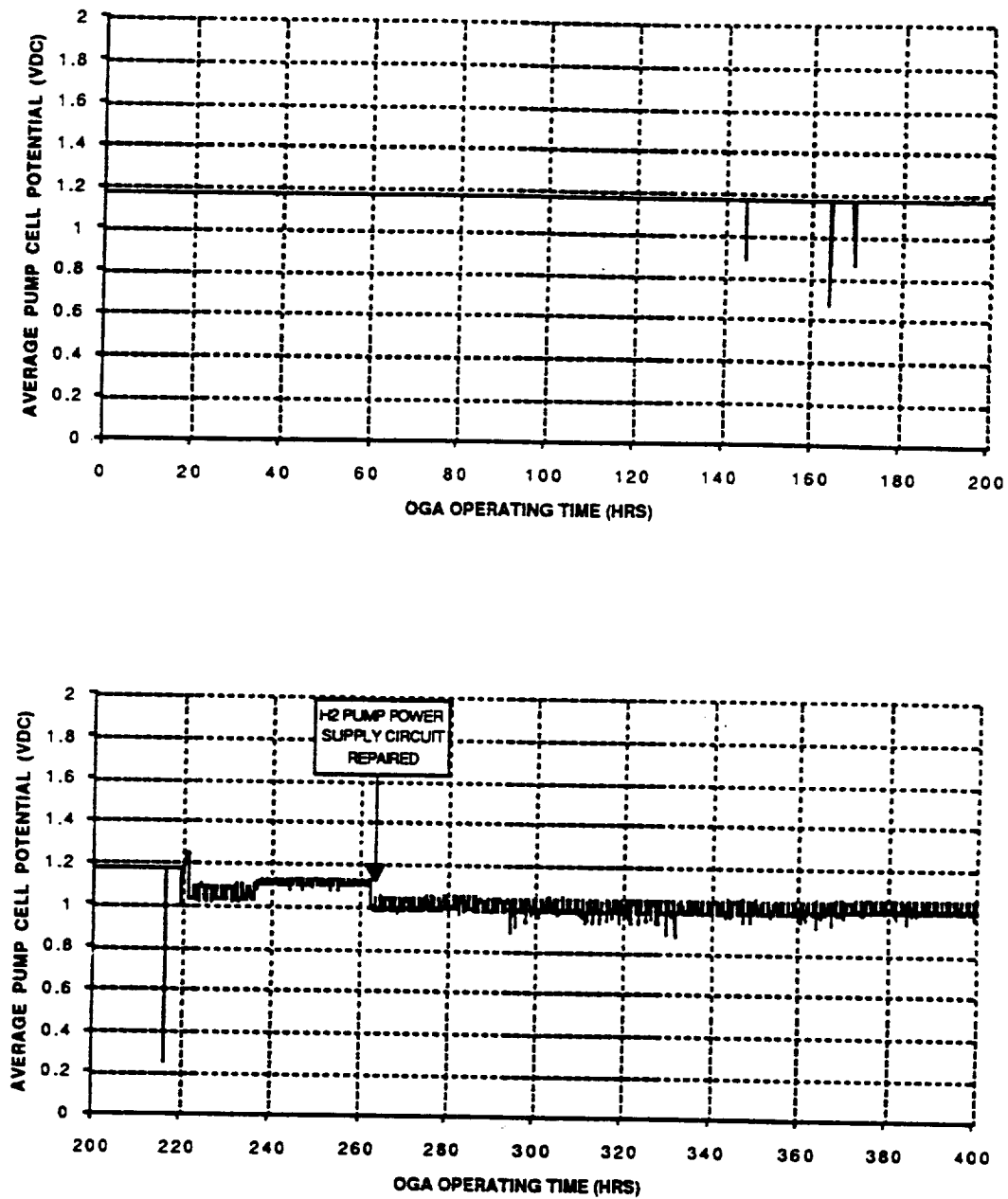


FIGURE 5.3-1 (CONT'D)
SPE OGA
HYDROGEN PHASE SEPARATOR PERFORMANCE

connected to the positive terminal of the electrochemical hydrogen pump cells provided a current path from the charged cells back to the power supply once power was removed from the supply. With voltage present at the contacts of the electrical contactor while the relay was switched, significant arcing occurred resulting in the contactor ultimately failing closed. The circuit was rewired to connect the power supply positive sense line directly to the power supply output line rather than the positive terminal of the hydrogen pump cells, thereby eliminating the current path back to the power supply. Corrections to the power supply control circuit were completed at the 265 hour mark, with satisfactory performance for the remainder of the test program. The average hydrogen pump cell potential and total cell current are presented in Figures 5.3-2 and 5.3-3, respectively. The cell potential is maintained at approximately 1 Vdc by the power supply; the total current typically varies between 0.25 amps for the standby level, and 0.50 amps for full production. Occasional spikes in the current are attributed to the in-rush current associated with charging completely discharged pump cells.

The hydrogen generation pressure is presented in Figure 5.3-4. The hydrogen pressure varies as a function of the generation rate due to the pressure drop across the Item 104-1 check valve, and the error associated with the Item 120 back pressure regulator. At approximately the 265 hour mark, the Item 053 purge valve experienced a shorted coil, resulting in a system shutdown and depressurization. The valve was removed and returned to the vendor to replace the coil and to add a heat sink to the valve housing to reduce the coil operating temperature. While the valve was being repaired, a spare valve was installed in its place and connected to the system plumbing with Teflon hoses. During this time period, the nitrogen inlet valve began cycling because the system nitrogen pressure was decaying. Since the regulator controlling hydrogen pressure is referenced to nitrogen, as the nitrogen pressure dropped the hydrogen pressure followed. In order to prevent the system from experiencing a shutdown due to low hydrogen pressure, the setpoint which controls the opening of the facility nitrogen valve was increased. The Item 053 valve was re-installed into the system at the 375 hour mark; performance of the nitrogen-reference hydrogen pressure control system was satisfactory for the remainder of the test program.



**FIGURE 5.3-2
SPE OGA
HYDROGEN PUMP VOLTAGE**

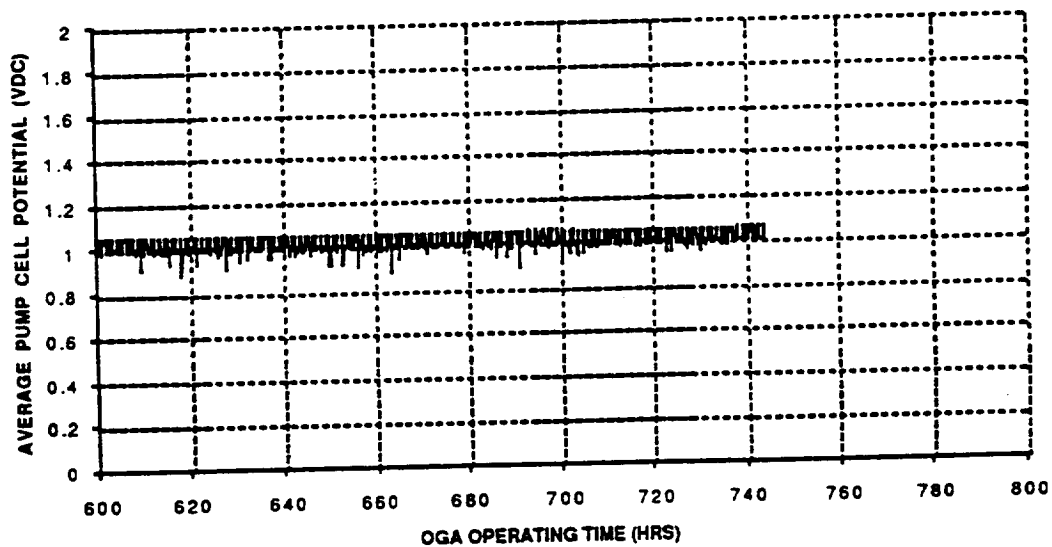
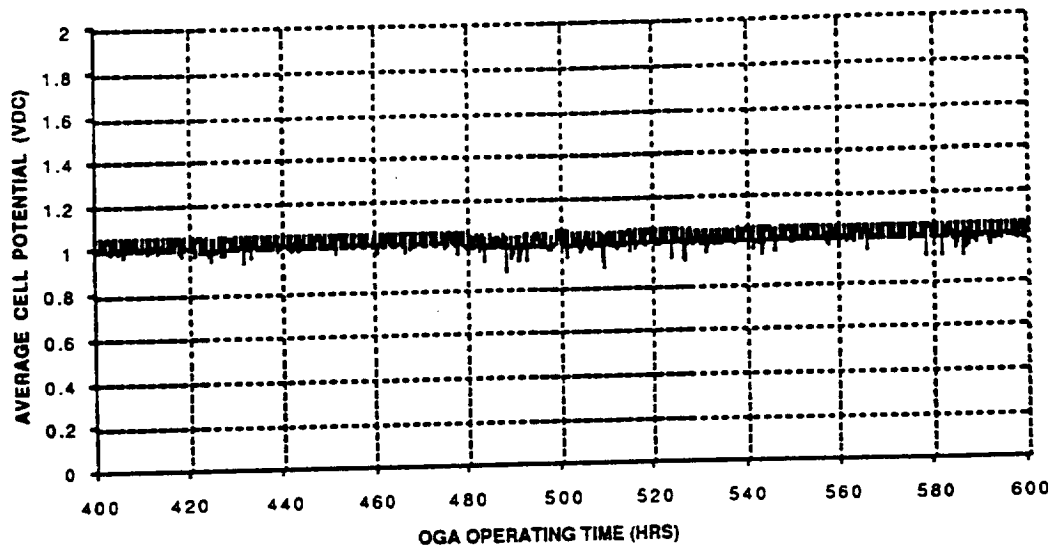


FIGURE 5.3-2 (CONT'D)
SPE OGA
HYDROGEN PUMP VOLTAGE

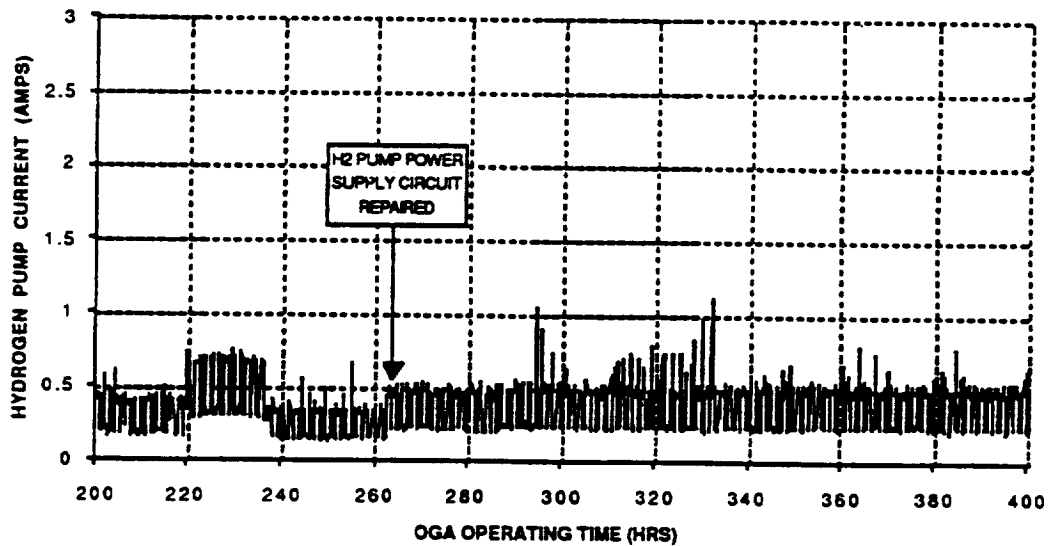
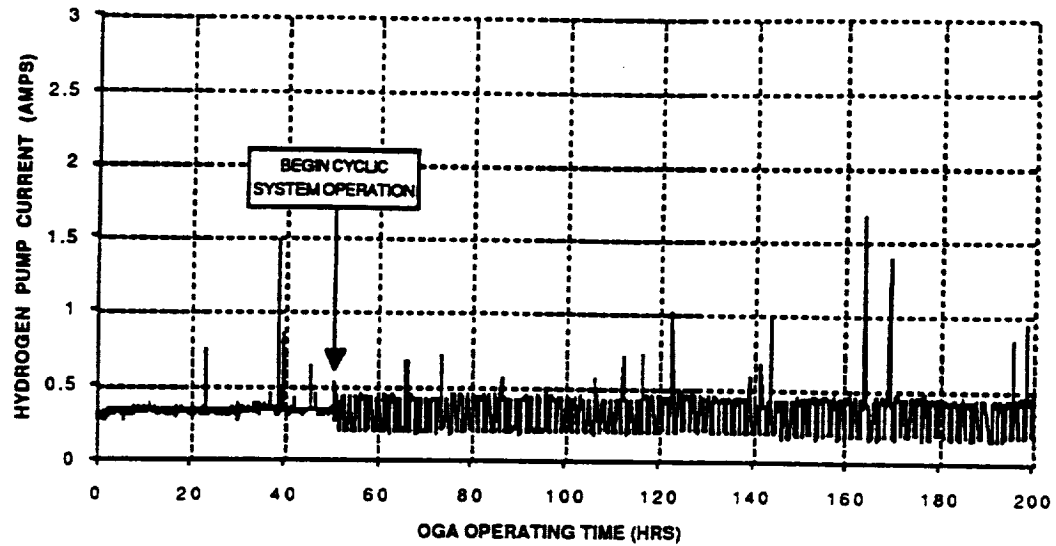


FIGURE 5.3-3
SPE OGA
HYDROGEN PUMP CURRENT

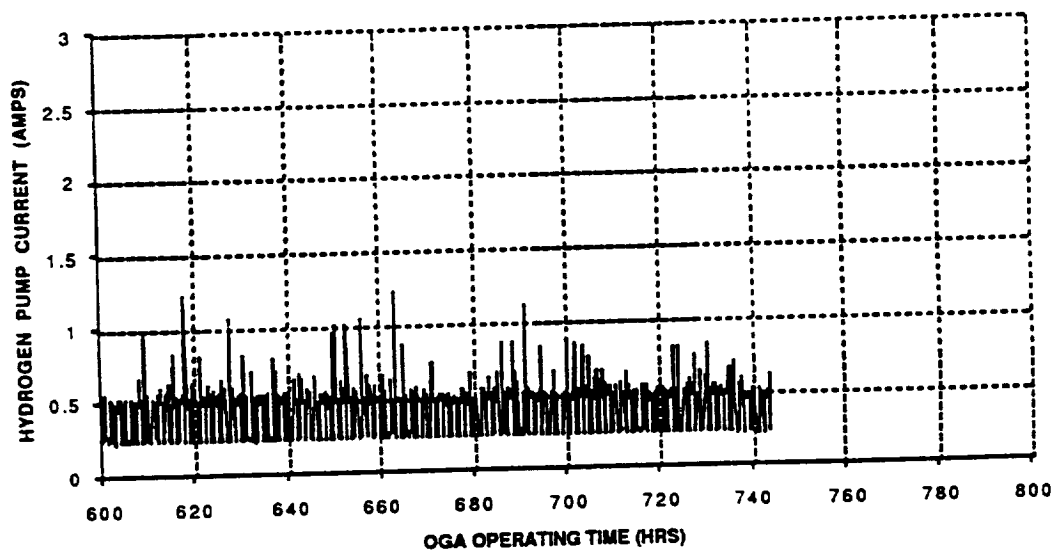
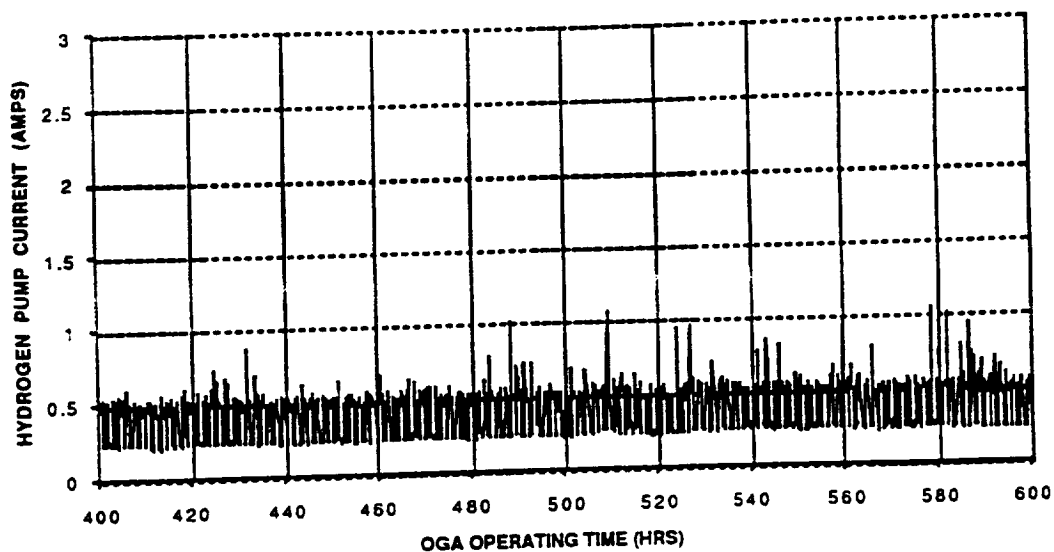


FIGURE 5.3-3 (CONT'D)
SPE OGA
HYDROGEN PUMP CURRENT

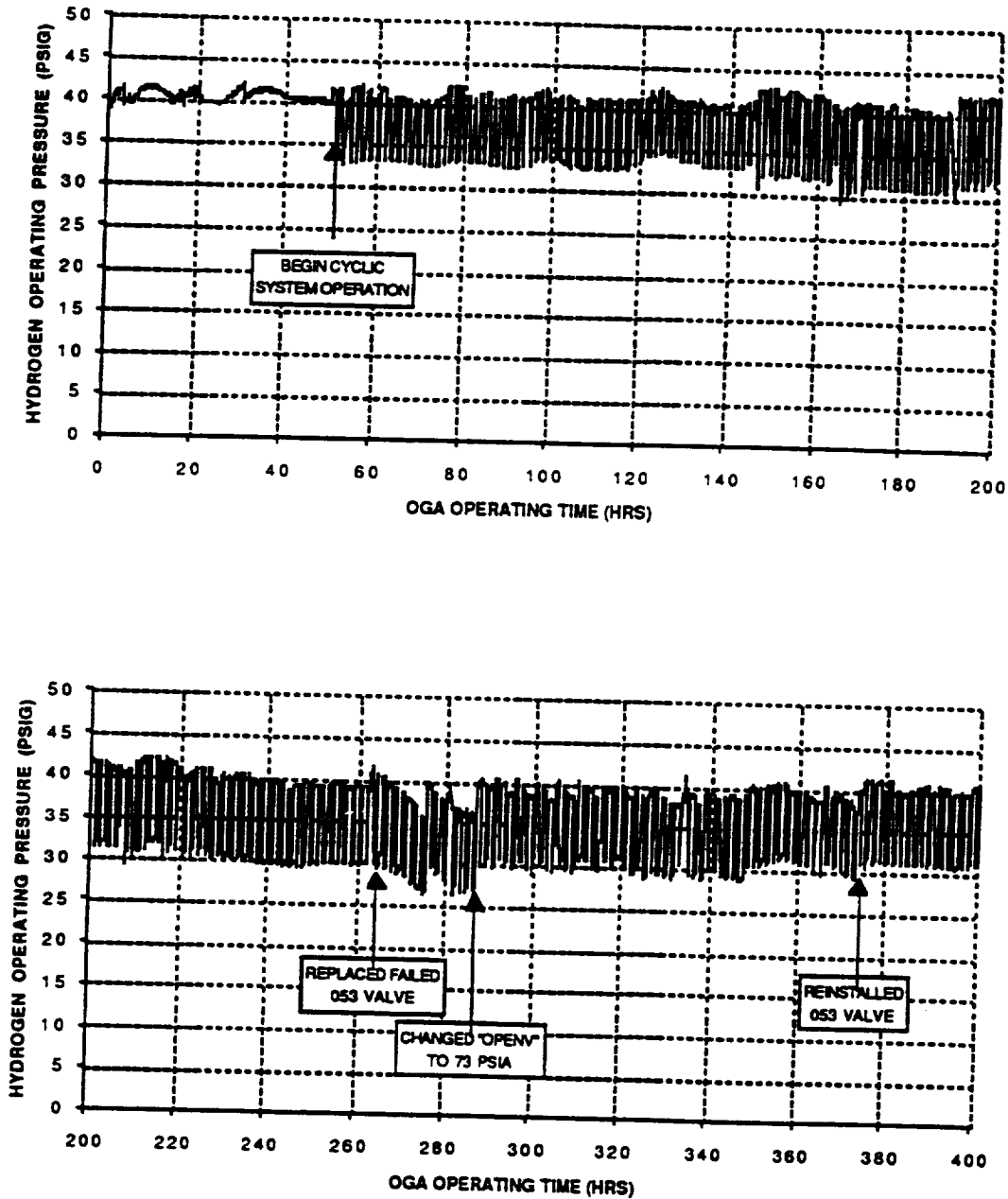


FIGURE 5.3-4
SPE OGA
HYDROGEN PRESSURE

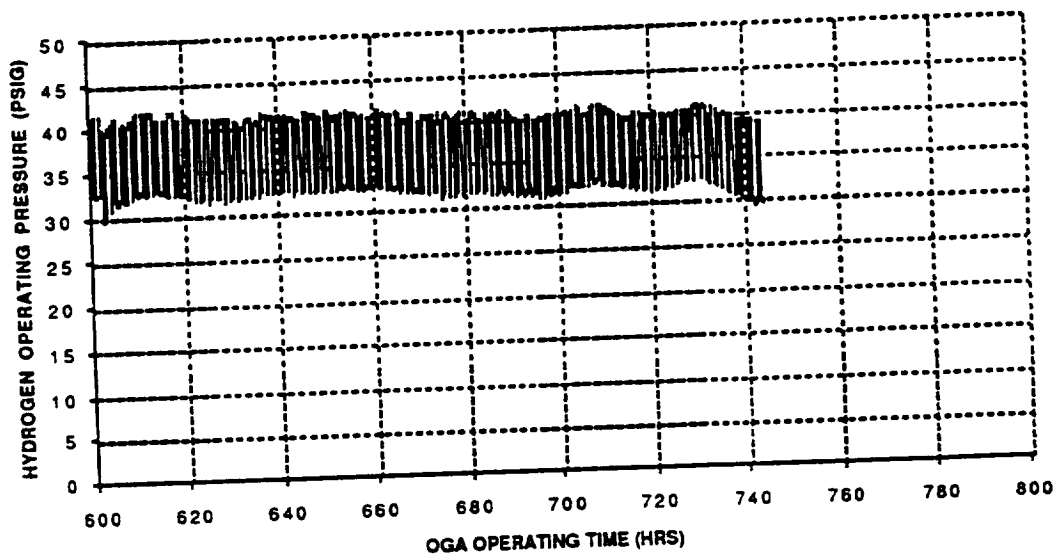
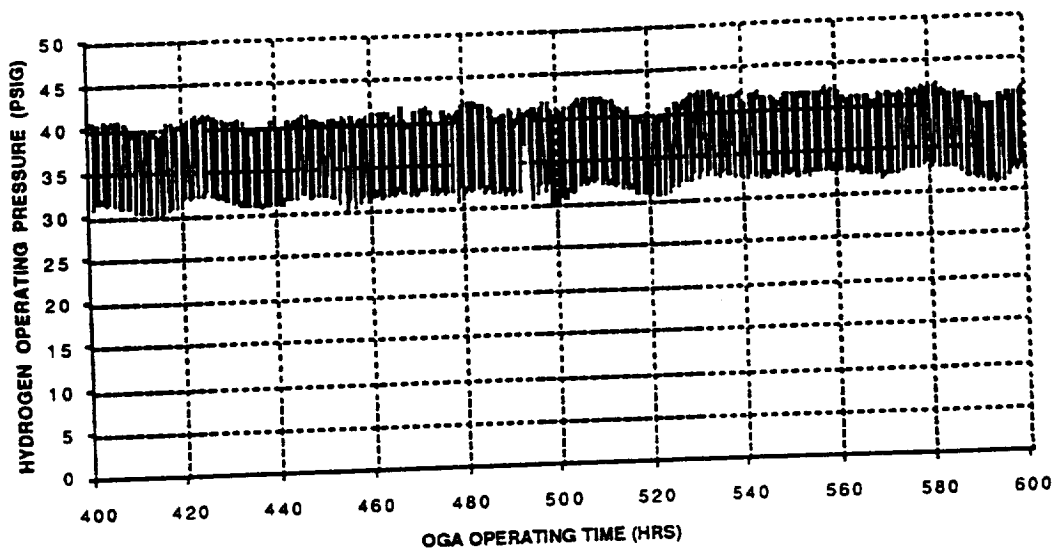


FIGURE 5.3-4 (CONT'D)
SPE OGA
HYDROGEN PRESSURE

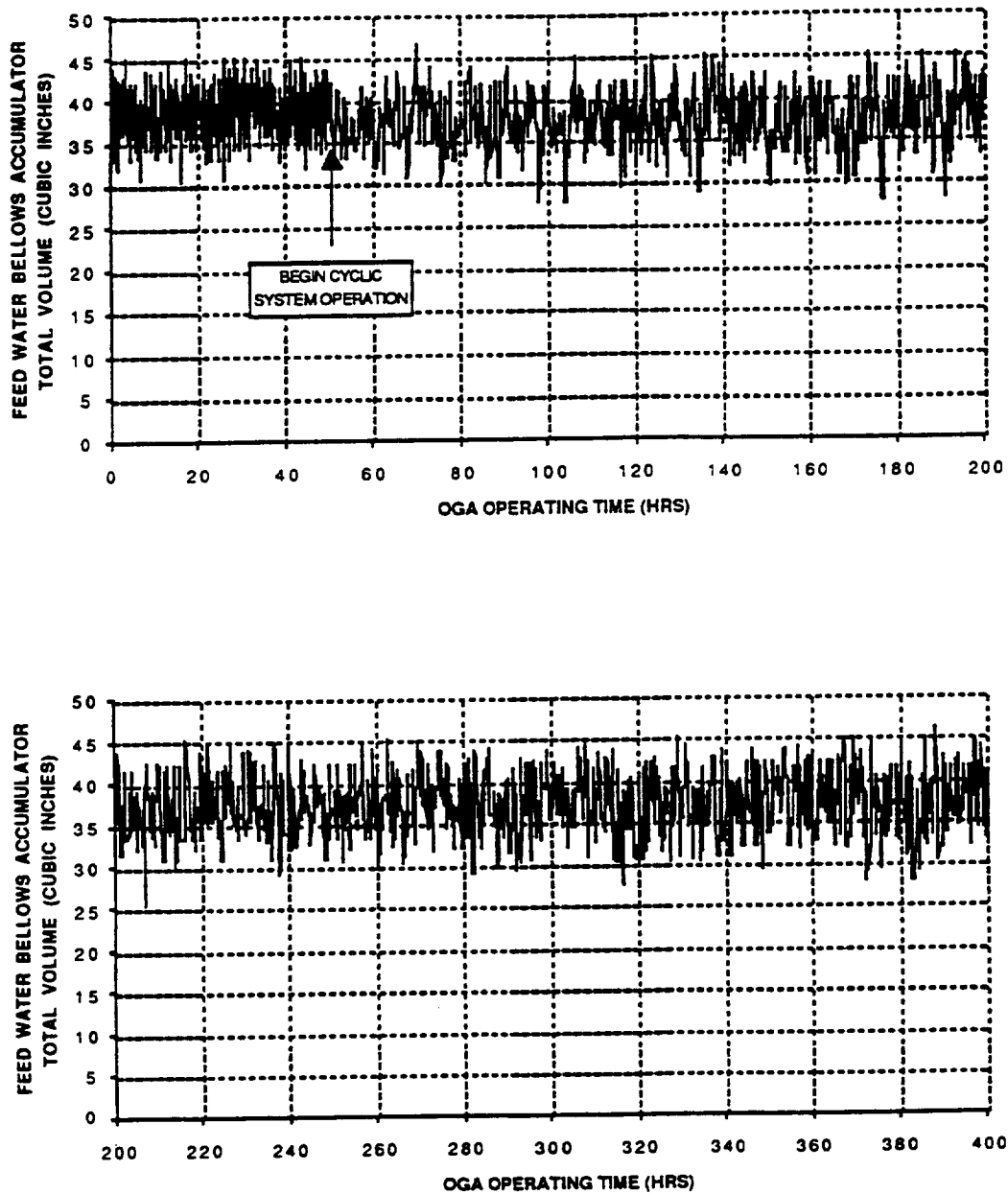
5.4 Feed Water Management

The redundant bellows accumulators (Items 605-1 and -2) manage the feed water from the facility as well as the protonically pumped water from the hydrogen phase separator. In addition, as outlined in the system description section, the fill rates and absolute volume of each tank serve as a method of diagnosing the health of the hydrogen phase separator assembly. During the first 475 hours of operation, the control laws governing operation of these dual accumulators were varied a number of times to try to match actual system performance. The variables that were adjusted included the factor used to calculate the proton water flow rate; the tolerance for the calculated fill rate versus the measured fill rate; the setpoints for introducing feed water into the tanks from the facility; and the maximum volume for each of the tanks. The first two variables were the most difficult to establish since the level sensors for the bellows accumulators, although they provide an analog output signal, take approximately 1 in³ step changes in their volume readings. During this time, the system experienced a few shutdowns due to improper filling of the bellows accumulators. The final control laws were implemented at the 475 hour mark; the operation of the bellows tanks was flawless for the remainder of the test program. Total water volume managed by the dual accumulators is presented in Figure 5.4-1.

5.5 Electronic Test Data

The software for the Command & Display Unit (CDU) was created to record data both on a line printer and to disk. When recording data to disk, the CDU writes the data to a buffer at the rate of once per second such that, in the event of a system failure, the CDU will record data for the 30 seconds preceding the event. The data from disk can be imported into a spreadsheet program for data manipulation and the generation of trend plots similar to those presented in this report.

During the conduct of this test program, data was recorded at the rate of once per minute to the line printer, and once every 5 minutes to the disk during normal operation. Rather than producing photocopies of the line printer



**FIGURE 5.4-1
SPE OGA
FEED WATER MANAGEMENT PERFORMANCE**

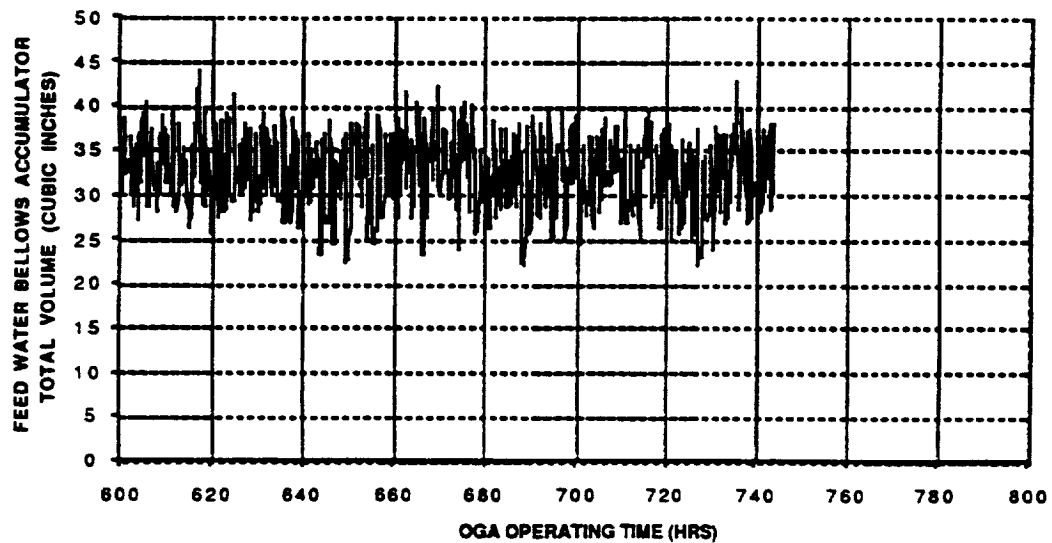
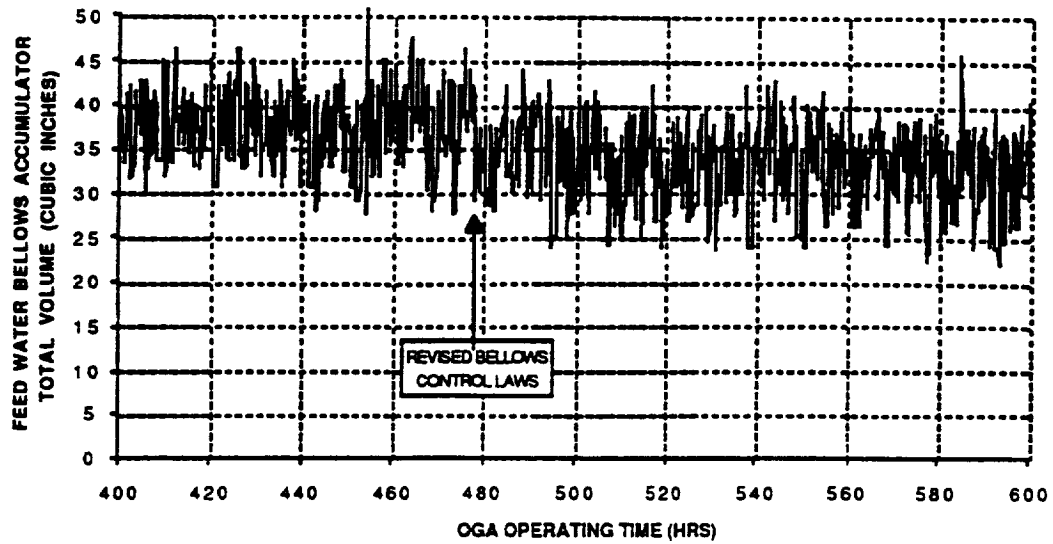


FIGURE 5.4-1 (CONT'D)
SPE OGA
FEED WATER MANAGEMENT PERFORMANCE

data, a set of 8 floppy disks containing the electronic data is being provided as part of this report. The data has been compressed and is stored in self-extracting archives. The self-extracting archives will work with any Macintosh computer model except the 128K and 512K. The extracting computer must be running System File 3.2 or higher, and it must have 313K bytes of free memory available. The files were created using Microsoft Excel 4.0, and compressed using Compact Pro, on a Macintosh II computer operating with System Software 7.0.1.

The data files have been manipulated into two categories: total data and process data. Total data represents all the test data, including data recorded in the PURGE, PROCESS-VENT, PROCESS, and FAILURE states. The process data files only contain data while the system was in the PROCESS state; this data was used in the generation of the trend plots presented in this report. The total data was useful for troubleshooting; however, since it contains all the test data, these data files can be cumbersome to work with.

6.0 FIELD SUPPORT

Hamilton Standard will verify proper installation of the SPE OGA into the NASA/MSFC test bed and will provide on-site support during the test program. This support will be provided primarily by Hamilton Standard personnel resident in Building 4755. In addition, Hamilton Standard personnel based in Windsor Locks, Connecticut, will be available as necessary to provide test support.

7.0 CONCLUSIONS AND RECOMMENDATIONS

The effort to refurbish the SPE Oxygen Generator Assembly has been extremely successful. The system has been revised to eliminate the operational deficiencies present in the original unit, and has successfully implemented other design changes to allow variable, cyclic oxygen generation in order to satisfy the new mission requirements for the ISSA. In particular, the SPE electrolyzer, oxygen/water and hydrogen/water phase separators, the three key elements of the SPE OGA, have demonstrated their unique ability

to perform over a wide range of variable operating conditions, and to adjust to those conditions rapidly. Transitions from the light side of the orbit to the dark are made instantaneously, while the reverse direction takes approximately 40 seconds and appears to be only limited by the performance of the back pressure regulator controlling the hydrogen phase separator. During this acceptance test program, the SPE OGA completed approximately 460 cycles simulating the space station orbit, demonstrating flawless performance of these technology items.

Since the goal of this effort was to develop a reliable, robust system that successfully demonstrated the viability and flexibility of the SPE OGA to meet the ISSA requirements, this technology demonstration system did not address other key issues such as weight, volume, or total system power requirements. The progression of the SPE OGA to a flight design could possibly include:

- 1) Reducing the weight of the cell stack and phase separator compression system, possibly through the use of composite end plates.
- 2) Reducing the weight of the nitrogen-hydrogen gas management system by eliminating the valve manifold and incorporating an all-welded tube assembly.
- 3) Reducing the power of ancillary equipment by using latching valve assemblies rather than solenoid valves, and eliminating the feed pump by resizing and redesigning the feed water bellows accumulators.
- 4) Fine tuning of the pressure control system for the hydrogen phase separator if the present transition rate from dark to light (approximately 40 seconds) is too long.

The refurbished SPE Oxygen Generator Assembly could serve as a test vehicle for evaluation of these and other design concepts that would allow for the steady development of a flight system.

APPENDIX A

MASTER TEST PLAN
FOR
BASELINE TESTING
OF THE
LFSPE OXYGEN GENERATING ASSEMBLY (OGA)
CONTRACT NO. NAS8-38250-23
SEPTEMBER 1994

1.0 OBJECTIVE

The purpose of this Master Test Plan is to define a series of tests to be performed on the LFSPE OGA prior to refurbishment of the unit. The OGA has been returned to Hamilton Standard to correct operational deficiencies identified during field testing of the unit, and to effect hardware and software changes to the system in order for it to be consistent with the most recent requirements for the International Space Station Alpha (ISSA). The tests to be conducted on the unit include reestablishing an operational baseline of key system components, in particular the electrolysis cell stack, the oxygen and hydrogen phase separator, and the fan/heat exchanger assembly. The data from this test program will be compared to that generated during the last baseline test conducted at NASA/MSFC in Building 4755 in December 1990.

2.0 TEST ARTICLE DESCRIPTION

The test article consists of a complete liquid anode feed water electrolysis system including a 12-cell SPE® water electrolyzer, water/oxygen phase separator and hydrogen/water phase separator, and a DC power supply cart with interconnecting cables. The package layout is defined in Hamilton Standard drawing number SVSK116600 Rev. A. Installation of the system into the facility will be in accordance with the Interface Control Document, TDH-ICD/99 Rev. E.

3.0 TEST PLAN

This section defines the tests to be performed on the LFSPE OGA once installation into the facility is complete. At the conclusion of each phase of the test program the test conductor and a separate reviewer will verify, by signature, that the tests were conducted in accordance with the test plan and the results recorded in the test plan were actual measurements. No other review of this test program is planned or anticipated.

3.1 Verify Installation

Prior to operation of the unit, proper installation into the test facility must be verified. For purposes of this test program, oxygen will be allowed to vent to the facility through the oxygen vent interface; hydrogen will be vented to the facility ventilation system through the hydrogen vent interface; DI water will be supplied by the facility DI water system; nitrogen will be supplied by the facility nitrogen farm; electrical power will be supplied by Rig 216 for the 115 Vac, 60 Hz 3 phase power; and 28 Vdc power will be supplied by a separate power supply.

Once installation into the facility is completed, the Command and Display Unit (CDU) software will be loaded into an IBM personal computer which will serve as the CDU. A harness linking the Electrical Interface Box (EIB)

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to the CDU will be installed, and a line printer to record system performance data will be connected to the computer.

Conducted by: Robert J. Fry 9/19/94 Verified by: L. P. Moulthrop

3.2 Verify Software Setpoints

PASSWORD: 937865

After verifying installation of the LFSPE OGA into the test facility, the unit can now be energized. Electrical power is provided to the system by turning the 115 Vac and 28 Vdc circuit breakers (CB1 and CB3, respectively) located at the top of the EIB to the "ON" position. Initiate the CDU program and verify the system status is in the OFF mode, OFF state, NORMAL status. Select the VIEW OPERATION screen by depressing the F6 key. Verify the values for the setpoints by comparing to the Static Parameters State Table (SYS-15) of the Software Requirements Specification for the LFSPE OGA, TDH-SRS/99 Rev. F (red-lined). A copy of the table is included for reference. Record and resolve any discrepancies between the values in the table and those displayed on the screen.

Conducted by: Robert J. Fry 9/19/94 Verified by: L. P. Moulthrop

3.3 Verify Manual Mode

PASSWORD: 815649

While in the OFF mode, OFF state, and with the system status NORMAL, select the MODE SELECTION screen by depressing the F3 key. Select the MANUAL mode. Depress the F5 key to select MANUAL OPERATION, and, at the prompt, enter the appropriate password to access the table. Actuate, in order and singularly, the components listed in the table. Deactivate each component upon verification of its proper operation, and record the test results on the hard copy of the MANUAL OPERATION screen included in this test plan. Record and resolve any problems encountered during actuation of any component. Some components may not be actuated in the MANUAL mode should the control laws governing their operation not be satisfied. Refer to the MANUAL MODE DEFINITION section of the SRS (SYS-21) for additional information.

Conducted by: Robert J. Fry 9/19/94 Verified by: L. P. Moulthrop

3.4 Baseline Test

A performance test of the LFSPE OGA will be conducted to establish a baseline for the electrolysis cell stack, the water/oxygen and hydrogen/water phase separators, and heat rejection requirements for the recirculating water loop. In addition, the test will verify the integrity of the system



STATIC PARAMETERS STATE TABLE

SYSTEM: LFSPE
COMMENTS:

PAGE 1 OF 1

PARAMETER NAME	UNITS	INV	V	POR	POSSIBLE STATE					
					OFF	PURGE	PRCVT	PROC	HOLD	FAIL
WARNT	DEG F INV	125		125	125	125	125	125	125	125
PAILT	DEG F INV	130		130	130	130	130	130	130	130
LOWCELL	VOLTS INV	1.3		1.3	1.3	1.3	1.3	1.3	1.3	1.3
HIGHCELL	VOLTS INV	2.1		2.1	2.1	2.1	2.1	2.1	2.1	2.1
LOWPUMP	VOLTS INV	0.1		0.1	0.1	0.1	0.1	0.1	0.1	0.1
HIGHPUMP	VOLTS INV	1.3		1.3	1.3	1.3	1.3	1.3	1.3	1.3
RECOMET	DEG F INV	180		180	180	180	180	180	180	180
TDIFF	DEG F INV	30		30	30	30	30	30	30	30
HIGHO2P	PSID INV	30		30	30	30	30	30	30	30
CHECKTIME	MIN INV	4.0		4.0	4.0	4.0	4.0	4.0	4.0	4.0
HIGHH2P	PSID INV	72.5		72.5	72.5	72.5	72.5	72.5	72.5	72.5
LOWO2P	PSID INV	10		10	10	10	10	10	10	10
LOWH2P	PSID INV	47.5		47.5	47.5	47.5	47.5	47.5	47.5	47.5
HIGHN2P	PSIA INV	208		208	208	208	208	208	208	208
AMPRESS	PSIA INV	30		30	30	30	30	30	30	30
O2FAIL	PSIA INV	220		220	220	220	220	220	220	220
HIGHCOND	UM/CM INV	10		10	10	10	10	10	10	10
VTIME	SEC INV	20		20	20	20	20	20	20	20
N2PTIME	MIN INV	2		2	2	2	2	2	2	2
ACCTIME	MIN INV	3		3	3	3	3	3	3	3
NOMI	AMPS INV	60		60	60	60	60	60	60	60
EMERG1	AMPS INV	79		79	79	79	79	79	79	79
STANDBY1	AMPS INV	6		6	6	6	6	6	6	6
HIGHIM	PSIA INV	190		190	190	190	190	190	190	190
VENTIME	MIN INV	10		10	10	10	10	10	10	10
STEPI	SEC INV	5		5	5	5	5	5	5	5
INCREMENT1	AMPS INV	4		4	4	4	4	4	4	4
CLOSEV	PSIA INV	195		195	195	195	195	195	195	195
OPENV	PSIA INV	185		185	185	185	185	185	185	185
HIGHAMP	AMPS INV	90		90	90	90	90	90	90	90
LEAKTIME	MIN INV	55		55	55	55	55	55	55	55
LEAKTIME2	MIN INV	1.5		1.5	1.5	1.5	1.5	1.5	1.5	1.5
LOWO2SEP	PSID INV	2		2	2	2	2	2	2	2
HIGHO2SEP	PSID INV	16		16	16	16	16	16	16	16
LOWH2SEP	PSID INV	2		2	2	2	2	2	2	2
HIGHH2SEP	PSID INV	10		10	10	10	10	10	10	10
LOWFLOW	GPM INV	0.20		0.20	0.20	0.20	0.20	0.20	0.20	0.20
HIGHFLOW	GPM INV	0.65		0.65	0.65	0.65	0.65	0.65	0.65	0.65
LOWPMP	GPM INV	0.012		0.012	0.012	0.012	0.012	0.012	0.012	0.012
MEDIUMPMP	GPM INV	0.015		0.015	0.015	0.015	0.015	0.015	0.015	0.015
HIGHPMP	GPM INV	0.018		0.018	0.018	0.018	0.018	0.018	0.018	0.018
RECIRC	GPM INV	0.48		0.48	0.48	0.48	0.48	0.48	0.48	0.48
HIGHSDLEV	CU IN INV	30		30	30	30	30	30	30	30
LOWSDLEV	CU IN INV	5		5	5	5	5	5	5	5
HIGHLEV	CU IN INV	25		25	25	25	25	25	25	25
MEDLEV	CU IN INV	14.5		14.5	14.5	14.5	14.5	14.5	14.5	14.5
LOWLEV	CU IN INV	10.5		10.5	10.5	10.5	10.5	10.5	10.5	10.5
HIGHTEMP	DEG F INV	120		120	120	120	120	120	120	120
LOWTEMP	DEG F INV	115		115	115	115	115	115	115	115
DELTIME	MIN INV	2.0		2.0	2.0	2.0	2.0	2.0	2.0	2.0
T1	SEC INV	10		10	10	10	10	10	10	10
T2	SEC INV	30		30	30	30	30	30	30	30
T3	SEC INV	30		30	30	30	30	30	30	30
T4	SEC INV	30		30	30	30	30	30	30	30
T5	SEC INV	30		30	30	30	30	30	30	30
T6	SEC INV	30		30	30	30	30	30	30	30
T7	SEC INV	10		10	10	10	10	10	10	10
T8	SEC INV	10		10	10	10	10	10	10	10
DEPRES1	% INV	0.15		0.15	0.15	0.15	0.15	0.15	0.15	0.15
DEPRES2	% INV	0.15		0.15	0.15	0.15	0.15	0.15	0.15	0.15
DELAY	SEC INV	30		30	30	30	30	30	30	30
STARTP	PSIA INV	50		50	50	50	50	50	50	50
H2SEP	MIN INV	1.5		1.5	1.5	1.5	1.5	1.5	1.5	1.5
YOPEN	MIN INV	5		5	5	5	5	5	5	5
PWDIFF	AMPS INV	5		5	5	5	5	5	5	5
PONTOPEN	% INV	0.50		0.50	0.50	0.50	0.50	0.50	0.50	0.50
IMAX	AMPS INV	0.5		0.5	0.5	0.5	0.5	0.5	0.5	0.5
INH6H	AMPS INV	0.2		0.2	0.2	0.2	0.2	0.2	0.2	0.2
H2TIME	SEC INV	30		30	30	30	30	30	30	30

CAME UP AS 0.0K FOR
NOW

10

0.018

0.021

0.024

CAME UP AS 1.0; OK

3.0

```

0000000011111111112222222223333333334444444445555555556666666667777777778
1234567890123456789012345678901234567890123456789012345678901234567890
1| DATE: XX-XX-XX          LFSPE OXYGEN GENERATION          TIME: XX:XX:XX          | 1
2| MODE: XXXXXXXXXXXXXXXX STATE: XXXXXXXXXXXXXXXX          STATUS: XXXXXXXXXXXXXXXX | 2
3|                                                                    | 3
4| OXYGEN PRODUCTION RATE: XX.XX LB/DAY          HYDROGEN PRODUCTION RATE: X.XX LB/DAY | 4
5| OPERATING TIME: XXXXX.X HOURS          LAST 800 LEVEL: X | 5
6|                                                                    | 6
7|          V003          CURRENT          SELECTION          | 6
8|          V005-1        XXXXXXXX          FILL1/DRAIN2        FILL2/DRAIN1 OK | 7
9|          V005-2        XXXXXXXX          VENT          PRODUCT DISABLED | 8
10|         V051-1        XXXXXXXX          VENT          PRODUCT DISABLED | 9
11|         V051-2        XXXXXXXX          CLOSED          OPEN OK | 10
12|         V053          XXXXXXXX          CLOSED          OPEN OK, BUT SET F11 NOTE (053 OPENED AT | 12
13|         V081-1        XXXXXXXX          OPEN          CLOSED OK | 12
14|         V081-2        XXX          CLOSED          OPEN OK; CLOSED | 13
15|         V081-3        XXXXXXXX          CLOSED          OPEN OK | 14
16|         V081-4        XXXXXXXX          CLOSED          OPEN OK | 15
17|        FAN422          XXX          OFF          ON OK | 16
18|        PMP463          XXX          OFF          ON OK | 17
19|        PMP464          XXXXXXXX          OFF          ON OK | 18
20| ANOMALY: XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX | 19
21| ADVICE:  XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX | 20
22|          XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX | 21
23| [F1] PAGE          [F4] CONFIG CNTRL          [F7] ACKNOWLEDGE          [10] MODIFY OPER | 22
24| [F2] SUBSYSTEM PARA [F5] MANUAL OPER          [F8] DATA LOGGING | 23
25| [F3] MODE SELECTION [F6] VIEW OPER          [F9] EXIT | 24
0000000011111111112222222223333333334444444445555555556666666667777777778
1234567890123456789012345678901234567890123456789012345678901234567890
    
```

NOTE: V051-2 APPEARS TO BE LEAKING; WITH VALVE CLOSED AND
 1) AT INTERFACE = 220 PSIG, OBSERVED P706-2, P749-1, P749-2
 INCREASING

SUBSEQUENT NOTE: AFTER CYCLING V051-2 A NUMBER OF TIMES, THE
 LEAK APPEARED TO GO AWAY. VALVE SEAT MAY
 HAVE HAD SOME CONTAMINATION, OR HAD TAKEN
 A SET DURING LONG TERM STORAGE. IN ANY
 EVENT, THE VALVE FUNCTION APPEARS TO BE OK.



SYS - 21

MANUAL MODE DEFINITION

SYSTEM: LFSPE

COMMENTS:

PAGE 1 OF 2

- (1) Power supply and power supply current are not allowed to be activated in the MANUAL mode; specifically PWR785, CNTL785, PS796 and PS797. All other devices can be altered manually.
- (2) The recirculating water pump, PMP463, and the feed water pump, PMP464, may be turned ON/OFF in the MANUAL mode. However, the following rules apply:
 - (a) If PMP464 = "ON" then:
PMP463 = "ON"
CNTL464 = "LOWPMP"
CNTL463 = "RECIRC"
V081-2 = "OPEN"
 - (b) If PMP464 = "OFF" then CNTL464 = 0.0 and V081-2 = "CLOSED".
 - (c) If PMP463 = "ON" then CNTL463 = "RECIRC"
 - (d) If the operator commands PMP463 = "OFF", the operator must manually set PMP464 = "OFF" first. If PMP464 = "OFF", then set CNTL464 = 0.0 and V081-2 = "CLOSED"; if PMP463 = "OFF" then CNTL463 = 0.0.
 - (e) While any of LEV606-4 thru -7 = "ON", then operator commands for PMP464 should be overridden by PMP464 = "OFF", CNTL464 should be set to 0.0 and V081-2 = "CLOSED".
- (3) Upon entering the MANUAL mode, if V003 position is unknown due to a cold software start (the last known position of the valve is lost from memory), then PMP464 = "OFF", CNTL464 = 0.0, V081-2 = "CLOSED" and V081-1 = "OPEN".
 - (a) If LEV605-1 increases by 0.5 cubic inches, set V003 position to FILL2/DRAIN1 and all associated variables to FILL2/DRAIN1, and command V081-1 = "CLOSED".
 - (b) If LEV605-2 increases by 0.5 cubic inches, set V003 position to FILL1/DRAIN2 and all associated variables to FILL1/DRAIN2, and command V081-1 = "CLOSED".

SYS - 21

MANUAL MODE DEFINITION

SYSTEM: LFSPE
COMMENTS:

PAGE 2 OF 2

- (4) The feed water inlet solenoid valve, V081-1, may be OPEN/CLOSED in the MANUAL mode. However, the following rules apply to prevent over extension of the feed water bellows accumulators, Items 605-1 and 605-2.

After the position of V003 is determined:

- (a) If V003 = "FILL1/DRAIN2" and

(1) If LEV605-2 < = "LOWLEV" then
command V081-1 = "OPEN"

(11) If LEV605-2 > = "MEDLEV" then
command V081-1 = "CLOSED"

- (b) If V003 = "FILL2/DRAIN1" and

(1) If LEV605-1 < = "LOWLEV" then
command V081-1 = "OPEN"

(11) If LEV605-1 > = "MEDLEV" then
command V081-1 = "CLOSED"

- (5) The water purging valves, V081-3 and V081-4, may be OPEN/CLOSED in the MANUAL mode. However, the following rules apply:

(a) If V081-3 = "OPEN", set V081-4 = "OPEN".

(b) If the operator commands V081-4 = "CLOSED", the operator must manually set V081-3 = "CLOSED" first.

- (6) The nitrogen inlet valve, V051-2, and the system nitrogen purge valve, V053, may be OPEN/CLOSED in the MANUAL mode. However, the following rule applies to prevent pressurizing the system:

(a) If P706-2 > = "AMBPRESS" psia, then set V053 = "OPEN".

loop. In addition, the test will verify the integrity of the system instrumentation and all actuated components prior to system refurbishment. Any malfunctioning component will be identified and repaired or replaced as necessary.

During the baseline test, a line printer will be connected to the CDU to record key operational data such as electrolysis cell potentials, phase separator membrane pressure drop and cell stack temperature rise. The data will be used, in part, as a baseline to determine the effectiveness of the system refurbishment.

Initiate baseline testing of the system by accessing the MODE SELECTION screen (depress the F3 key) and selecting the ON mode. The system will transition from the OFF mode OFF state to the ON mode PURGE state. Refer to the SRS to verify proper sequencing of components within the system during the PURGE state. Record any discrepancies observed while in the PURGE state, particularly operation of the recirculation pump, Item 463, and the recirculation loop bellows accumulator, Item 606. Operation of these two components to effectively purge the recirculation loop of gas during start-up was ineffective during testing of the unit at NASA/MSFC.

After satisfying the requirements of the PURGE state, the system will transition to the PROCESS-VENT state. At this point, the electrolysis power supplies are activated and DC power is supplied to the cell stack. Pressurization of the oxygen and hydrogen circuits in the system coincides with gas generation. Record any discrepancies observed while in the PROCESS-VENT state, particularly the quality of the hydrogen vent line. During testing of the unit at NASA/MSFC, a significant quantity of water was present in the delivery line at low hydrogen operating pressures. Monitor cell potentials and pressure differentials across both phase separators once gas generation has begun.

Once the requirements of the PROCESS-VENT state are satisfied, the system will transition to the PROCESS state. Since the 3-way solenoid valves that redirect the flow of the product gases from the VENT interface to the OUTLET interface failed during testing in the field, there is no change in the system status when going from these two states. Once in the PROCESS state, select the CONFIGURATION CONTROL screen by depressing the F4 key and select the EMERGENCY setting. Verify the current to the electrolysis cell stack increases from 60 amps to 79 amps. Return to the CONFIGURATION CONTROL screen, and return the system setting to NORMAL. Operate the unit at both the NORMAL and EMERGENCY settings for sufficient time to observe any trends in performance of key system components, such as cell potentials and phase separator membrane pressure drop. Continue to record test data on the line printer for the duration of the baseline test program.

Conducted by: Robert J. Loy
completed: 9/28/94

Verified by: Lawrence P. Moulthrop

TABLE 3.4-1

BASELINE TESTING DISCREPANCIES AND RESOLUTIONS

Date	Discrepancy	Resolution
9-17-94	<ul style="list-style-type: none"> • HIGH I908 CURRENT SHUTDOWN @ 10:52:41 • HIGH I908 CURRENT SHUTDOWN @ 11:41:57 • HIGH I908 CURRENT SHUTDOWN @ 12:14:12 • HIGH I908 CURRENT SHUTDOWN @ 13:44:47 • HIGH CELL VOLTAGE SHUTDOWN @ 13:07:06 • REACHED PROL-VENT STATE AT 13:50:38; NOTICED THAT I908 SENSE CELL CURRENT CONTINUED TO CLIMB; STRIPPER CELL CURRENTS (I768-1 THRU -4) STAYED IN THE NOISE LEVEL 	<ul style="list-style-type: none"> RE-START; POSSIBLY H₂ LEFT IN CELL AFTER LONG TERM STORAGE RE-START; SAME AS ABOVE RE-START; SAME AS ABOVE RE-START; INCREASE SETPOINT TO 2 AMPS RE-START; INCREASE SETPOINT TO 2.5 VDC (FROM 2.1 VDC) • CHECK OPERATION OF STRIPPER CELLS POWER SUPPLY; CHECK OPERATION OF STRIPPER RAMPING CIRCUIT. (NOTE: INSTALLED SEPARATE POWER SUPPLY FOR STRIPPER CELLS).
9-20-94	<ul style="list-style-type: none"> • LOW CELL VOLTAGE @ 10:02:46; BREAKER ON CIB WAS SET TO "OFF" POSITION • LONG PURGE STATE DUE TO INADEQUATE PRIMING • HIGH ITEM 606 LEVEL @ 11:17:46 • ATTEMPTED TO RE-START; DRAIN WATER FROM LOOP TO REDUCE BELLOW TANK LEVEL (SEE ABOVE). • ACHIEVED (SUCCESSFULLY) PROL-VENT STATE @ 15:58:21; STRIPPER CELLS CURRENT RISING STEADILY; I908 APPEARS OK. 	<ul style="list-style-type: none"> • TURN BREAKER "ON" • TO BE CORRECTED AS PART OF THE SYSTEM REFURBISHMENT • BELLOW TANK LEVEL CONTROL WILL NEED TO BE MODIFIED TO ALLOW FOR RAPID EXPANSION DURING TRANSITION FROM DARK TO LIGHT CYCLE. • DRAINED TOO SOON; MUST WAIT UNTIL TIMER WELPTIME HAS STARTED. • STRIPPER CELL POWER SUPPLY FAILED; NEED TO CORRECT RAMPING CIRCUIT (CURRENT CONTROL) AND INSTALL NEW PERMANENT SUPPLY.

TABLE 3.4-1
BASELINE TESTING
DISCREPANCIES AND RESOLUTIONS

<u>Date</u>	<u>Discrepancy</u>	<u>Resolution</u>
9-22-94	<ul style="list-style-type: none"> • ACHIEVED PROCES STATE AT 9:21:55; OBSERVED NO DISCREPANCY REGARDING FAN/HEX PERFORMANCE. • SHUTDOWN @ 17:06:47 DUE TO LACK OF FACILITY DI WATER • OBSERVED NO 1908 HIGH LEVEL WARNINGS OR S/D'S. 	<ul style="list-style-type: none"> • DI WATER SHUT-OFF OVERNIGHT; WILL ADVISE PERSONNEL TO LEAVE WATER "ON".
9-23-94	<ul style="list-style-type: none"> • HIGH ITEM 606 LEVEL S/D @ 09:26:59 	<ul style="list-style-type: none"> • SEE 9-20-94, 11:17:46
9-24-94	<ul style="list-style-type: none"> • LOW ITEM 606 LEVEL S/D @ 14:26:32 	<ul style="list-style-type: none"> • POSSIBLY WORN VALVE IN FEED PUMP; INCREASE PUMP SPEED AND OBSERVE ANY FUTURE OCCURRENCES.
9-25-94	<ul style="list-style-type: none"> • TRIED TO RE-START AFTER S/D OF 9-24-94 @ 14:26:32; UNABLE TO WITHSTAND ANY ASSISTANCE TO DRAIN LOOP 	<ul style="list-style-type: none"> • WAIT FOR ADDITIONAL LAB PERSONNEL ON 9-26-94
9-26-94	<ul style="list-style-type: none"> • FACILITY POWER FLICKERED, CAUSING S/D @ 08:30:58 • S/D @ 10:08:09 DURING CHANGE OF FEED PUMP SPEED SETTING • S/D @ 14:53:29 DURING CHANGE OF FEED PUMP SPEED SETTING • TWO RE-STARTS RESULTED IN LOW H₂ SEPARATION AT S/D'S • NOTE: COLLECTED 35 CC AND 40 CC OF WATER DURING TWO OF THE START-UPS IN THE H₂ DELIVERY LINE 	<ul style="list-style-type: none"> • RE-START • RE-START; EXAMINE EEB COMMUNICATIONS DURING SYSTEM REFURBISHMENT • SEE ABOVE • RE-EXAMINE SETPOINT VALUES FOR NEW SEPARATION CONFIGURATION IN REFURBISHED SYSTEM. • SEPARATOR CONFIGURATION TO BE MODIFIED TO PRECLUDE WATER CARRY-OVER DURING START-UP.

TABLE 3.4-1
BASELINE TESTING
DISCREPANCIES AND RESOLUTIONS

<u>Date</u>	<u>Discrepancy</u>	<u>Resolution</u>
9-27-94	<ul style="list-style-type: none"> • S/D + 0.00000 WHILE CHANGING SETPOINTS FOR N₂ REFERENCE (SET REFERENCE FOR 100 PERCENT OPERATION). • HIGH ITEM LOG LEVEL FID @ 10:40:17 • SET TO "EMERGENCY" MODE @ 13:12:05 (CURRENT INCREASED FROM 75 AMPS TO 79 AMPS) • OBSERVED NO DISCREPANCY - VOLTAGE 	<ul style="list-style-type: none"> • SEE 9-26-94, 10:08:09 • SEE 9-20-94, 11:17:46
9-28-94	<ul style="list-style-type: none"> • OBSERVED 2908 REMAINED AT 0.000 DURING MAJORITY OF TEST ON 9-27-94 & 9-28-94 • OBSERVED NO DISCREPANCY AT 79 AMPS WITH FAN/HEX PERFORMANCE • RETURNED UNIT TO "NORMAL" MODE @ 08:34:58 (CURRENT DECREASED FROM 79 AMPS TO 60 AMPS). • TOTAL TIME IN PROCESS: 56.9 HOURS 	<ul style="list-style-type: none"> • LOOSE CONNECTION DISCOVERED IN EIR DURING POST TEST INSPECTION • WILL NEED TO TROUBLESHOOT ONLY IF SENSE CELL FUNCTION REMAINS IN REFURBISHED UNIT.

A-14

A-17

01015 NOV 30 11 2100
00110720039 039170 345A

13-VENT
WIND CLOS-
RETRACT-
PULSANT 0.0
TO TOWN 0.0
CLOUT 0.0
SHOULDER 0.0
WIND 0.0
(DID 0.0
TWO 0.0
LAW) 0.0

31STIS MONTH 31ST
DATE TIME MONTH STATE

A-20

THE SON
IN NAME STATE
(SEE CONTINUED PAGE
SAS REV. F)

[illegible]

DATE: 26-SEP-99	TYPE: OTDRN	TIME: 15:54:30
DATE: 00	STATE: PROCESS-NEW	SIGNS: NORMAL
OTDRN PRODUCTION RATE: 3.00 LOT/MT	OTDRN PRODUCTION RATE: 0.70 LOT/MT	
OTDRN TIME: 0.00 HOURS	LAST DAY LEVEL: 0	
OTDRN-1: -2.0 DEL	OTDRN-1: 1.210 V	OTDRN-1: 1.000 V
OTDRN-2: -2.0 DEL	OTDRN-2: 1.210 V	OTDRN-2: 1.000 V

DRAWN WATER FROM
PLOT-3, T42-1-2 HOUSING-

1740-1	0.266	0
1740-2	0.230	0
1740-3	0.271	0
1740-4	0.282	0
1900	0.463	0
1910-1	1.017	0
1910-2	1.003	0
1910-3	1.033	0
1910-4	1.046	0
1910-5	1.000	0
1910-6	1.040	0
1910-7	1.040	0
1910-8	1.040	0
1910-9	1.040	0
1910-10	1.040	0
1910-11	1.040	0
1910-12	1.040	0
1910-13	1.040	0
1910-14	1.040	0
1910-15	1.040	0
1910-16	1.040	0
1910-17	1.040	0
1910-18	1.040	0
1910-19	1.040	0
1910-20	1.040	0
1910-21	1.040	0
1910-22	1.040	0
1910-23	1.040	0
1910-24	1.040	0
1910-25	1.040	0
1910-26	1.040	0
1910-27	1.040	0
1910-28	1.040	0
1910-29	1.040	0
1910-30	1.040	0
1910-31	1.040	0
1910-32	1.040	0
1910-33	1.040	0
1910-34	1.040	0
1910-35	1.040	0
1910-36	1.040	0
1910-37	1.040	0
1910-38	1.040	0
1910-39	1.040	0
1910-40	1.040	0
1910-41	1.040	0
1910-42	1.040	0
1910-43	1.040	0
1910-44	1.040	0
1910-45	1.040	0
1910-46	1.040	0
1910-47	1.040	0
1910-48	1.040	0
1910-49	1.040	0
1910-50	1.040	0
1910-51	1.040	0
1910-52	1.040	0
1910-53	1.040	0
1910-54	1.040	0
1910-55	1.040	0
1910-56	1.040	0
1910-57	1.040	0
1910-58	1.040	0
1910-59	1.040	0
1910-60	1.040	0
1910-61	1.040	0
1910-62	1.040	0
1910-63	1.040	0
1910-64	1.040	0
1910-65	1.040	0
1910-66	1.040	0
1910-67	1.040	0
1910-68	1.040	0
1910-69	1.040	0
1910-70	1.040	0
1910-71	1.040	0
1910-72	1.040	0
1910-73	1.040	0
1910-74	1.040	0
1910-75	1.040	0
1910-76	1.040	0
1910-77	1.040	0
1910-78	1.040	0
1910-79	1.040	0
1910-80	1.040	0
1910-81	1.040	0
1910-82	1.040	0
1910-83	1.040	0
1910-84	1.040	0
1910-85	1.040	0
1910-86	1.040	0
1910-87	1.040	0
1910-88	1.040	0
1910-89	1.040	0
1910-90	1.040	0
1910-91	1.040	0
1910-92	1.040	0
1910-93	1.040	0
1910-94	1.040	0
1910-95	1.040	0
1910-96	1.040	0
1910-97	1.040	0
1910-98	1.040	0
1910-99	1.040	0
1910-100	1.040	0
1910-101	1.040	0
1910-102	1.040	0
1910-103	1.040	0

—

22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	4	1.005	125	177	102	2.40	4.30	42	17	117	99	0.42	12.4	15.1	40	0.910	0.903	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.009	175	116	101	2.72	4.05	42	17	110	97	0.43	12.5	15.2	40	0.907	0.902	0.905	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.021	175	117	101	2.75	4.06	42	17	115	98	0.44	12.5	15.2	40	0.909	0.903	0.906	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.012	175	117	101	2.75	4.06	42	17	116	99	0.44	12.6	15.2	40	0.908	0.903	0.906	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	2	1.012	175	116	103	2.40	4.30	42	14	117	98	0.42	12.6	15.2	40	0.908	0.903	0.906	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	2	1.013	175	116	103	2.41	4.30	42	14	110	99	0.44	12.9	15.2	40	0.909	0.904	0.907	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	0.922	
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.006	177	117	105	2.72	4.07	42	14	110	99	0.42	13.1	15.2	40	0.908	0.902	0.905	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.006	177	117	104	2.71	4.16	42	14	110	99	0.42	13.9	15.5	40	0.908	0.902	0.905	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.006	177	117	105	2.72	4.05	42	14	117	91	0.45	11.3	12.4	40	0.908	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	4	1.012	175	116	103	2.71	4.05	42	17	110	91	0.44	12.5	15.1	40	0.906	0.903	0.906	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.026	175	117	107	2.71	4.05	42	17	115	99	0.46	12.9	15.1	40	0.908	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.013	175	116	101	2.71	4.09	42	17	116	91	0.46	13.1	15.2	40	0.906	0.902	0.905	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	2	1.010	177	117	103	2.45	4.23	42	14	117	99	0.44	16.4	15.2	40	0.904	0.902	0.904	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	2	1.009	180	117	105	2.45	4.23	42	14	110	99	0.44	12.5	12.4	40	0.908	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.010	177	117	105	2.71	4.26	42	14	110	91	0.47	12.7	11.4	40	0.903	0.902	0.903	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.007	177	117	105	2.73	4.06	42	14	110	91	0.45	15.2	12.6	40	0.902	0.902	0.903	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	3	1.004	179	116	106	2.40	4.20	42	14	110	91	0.44	11.3	13.9	40	0.907	0.903	0.906	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.4	4	1.002	176	117	103	2.40	4.30	42	17	117	92	0.47	12.4	11.9	40	0.906	0.903	0.906	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921
22-SEP-94 10:37:03 500 PROCESS	11.31	1.40	1.7	3	1.012	175	117	102	2.75	4.44	42	17	115	91	0.47	13.9	11.9	40	0.904	0.903	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918
22-SEP-94 10:37:03 500 PROCESS	11.26	1.40	1.7	3	1.019	175	117	102	2.78	4.59	42	17	114	92	0.46	15.1	13.4	40	0.902	0.902	0.903	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.7	2	1.011	176	117	102	2.72	4.01	42	17	117	92	0.44	16.3	11.8	40	0.908	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921	0.922	0.923
22-SEP-94 10:37:03 500 PROCESS	11.29	1.40	1.8	2	1.010	179	117	105	2.40	4.42	42	14	117	92	0.41	12.7	11.3	40	0.906	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.8	2	1.007	179	117	106	2.71	4.79	42	14	110	92	0.42	15.1	12.5	40	0.906	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.21	1.40	1.8	3	1.005	179	116	104	2.71	4.33	42	14	110	92	0.46	12.8	11.3	40	0.905	0.902	0.905	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.19	1.39	1.8	3	1.004	179	117	104	2.74	4.44	42	14	119	92	0.42	14.0	15.1	40	0.902	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919
22-SEP-94 10:37:03 500 PROCESS	11.24	1.40	1.8	3	1.004	179	117	108	2.74	4.35	42	14	119	92	0.44	12.4	12.7	40	0.903	0.903	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918
22-SEP-94 10:37:03 500 PROCESS	11.27	1.40	1.8	4	1.012	177	117	106	2.75	4.22	42	14	119	92	0.41	16.4	11.3	40	0.903	0.903	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.8	3	1.019	175	117	102	2.72	5.00	42	17	115	93	0.43	15.9	13.9	50	0.905	0.900	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.30	1.40	1.9	3	1.012	176	117	102	2.74	5.00	41	17	116	92	0.44	15.1	15.2	40	0.906	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921
22-SEP-94 10:37:03 500 PROCESS	11.21	1.40	1.9	3	1.009	176	117	102	2.74	5.00	41	17	117	92	0.44	15.1	16.3	40	0.906	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921
22-SEP-94 10:37:03 500 PROCESS	11.25	1.40	1.9	2	1.004	178	117	105	2.71	4.35	41	15	110	92	0.41	15.1	17.7	40	0.903	0.902	0.905	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.29	1.40	1.9	2	1.004	179	117	108	2.73	4.72	41	14	110	93	0.40	12.4	18.9	40	0.906	0.902	0.905	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920
22-SEP-94 10:37:03 500 PROCESS	11.20	1.40	1.9	3	1.003	179	117	105	2.73	4.72	40	14	119	93	0.41	12.5	17.8	40	0.906	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919	0.920	0.921
22-SEP-94 10:37:03 500 PROCESS	11.23	1.40	1.9	3	1.003	178	117	105	2.74	4.94	40	14	119	93	0.41	15.1	15.1	40	0.904	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918	0.919
22-SEP-94 10:37:03 500 PROCESS	11.19	1.39	2.0	3	1.003	178	117	105	2.74	4.94	40	14	119	93	0.41	15.1	12.5	40	0.903	0.903	0.904	0.905	0.906	0.907	0.908	0.909	0.910	0.911	0.912	0.913	0.914	0.915	0.916	0.917	0.918
22-SEP-94 10:37:03 500 PROCESS	11.32	1.40	2.0	3	1.012	176	117	105	2.72	5.03	40	15	110	93	0.40	15.0	11.4	40	0.909	0.907	0.907	0.908	0.9												

A-30

DATE: 22-SEP-94		TYPE: ATGEN GENERATION		TIME: 13:10:43	
DATE: 06		STATE: PROCESS		STATUS: NORMAL	
ATGEN PRODUCTION DATE: 11/17/94 AT ATGEN PRODUCTION RATE: 1.39 13/94 AT OPERATING TIME: 3.5 HOURS LOST JOB LEVEL: 0					
02740-1	-2	3 101	02740-1	3 101	0
02740-2	-9	3 101	02740-2	3 101	0
02740-3	0	3 101	02740-3	3 101	0
02740-4	-1	3 101	02740-4	3 101	0
02755	0.0 0000/00	027000	1.100	0	0
1710	00 0000	027000	1.003	0	0
1710-1 0.310 A 027000-1 1.020 A 1710-2 0.320 A 027000-2 1.795 A 1710-3 0.327 A 027000-3 1.782 A 1710-4 0.310 A 027000-4 1.005 A 1900 0.056 A 027000-12 1.002 A 027000-1 1.003 A					

ADVICE:
ADDITIONAL:

[illegible]

A-32

A-33

A-34

A-37

A-38

DATE: 23-SEP-90
TIME: 12:12:43
LSP# GIVEN GENERATION
STAT# PROCESS
STAT# MODAL
CONF. ON

HYDROGEN PRODUCTION RATE: 1.40 L/DAY

OPERATING TIME	0.8 HOURS	LOG LEVEL, J
0005-1 P000001	LE0000-1 OFF	0700-1 179 PS10
0005-2 P000001	LE0000-2 OFF	0700-2 197 PS10
0005-3 P000001	LE0000-3 OFF	0700-3 105 PS10
0005-1 C10500	LE0000-0 OFF	00700 2,271 PS10
0005-2 C10500	LE0000-3 OFF	00700 6,432 PS10
0005-3 C10500	LE0000-4 OFF	00700-1 43 PS10
0005-1 C10500	LE0000-5 OFF	00700-2 35 PS10
0005-2 C0000	P00700 00	1702-1 110 F
0005-3 C10500		1702-2 119 F
0005-1 C10500	CE0000 0,43 000	1703-1 91 F
0005-2 C10500	CE0000-1 11,4 00 10	1703-2 94 F
0005-3 C10500	CE0000-2 12,3 00 10	0710 175 PS15
0005-1 C0000		

1. JOURNAL
1. JOURNAL

(F1) PAGE	(F6) COUNT IS CTRIL	(F7) ACKNOWLEDGE	(F10) NOTIFY OPEN
(F2) SUBMITTER PARA	(F3) MANUAL OPEN	(F8) DATA LOGGING	
(F3) NODE SELECTION	(F4) VIEW OPEN	(F9) EDIT	PAGE 1 OF 2

DATE: 21-SEP-90 06:10:00
 NAME: MARY
 SSN: 012345678
 STATUS: MARRIED
 TIME: 12:12:54

BUTCHER PRODUCTION RATE: 11.90 LB/DAY HYDROGEN PRODUCTION RATE: 3.41 LB/DAY
OPERATING TIME: 8.0 HOURS LAST AVE LEVEL: 0
6574-1-1 1 CEL M270P-1.020 V M1996-1 1.002 V

6 25 1 3500

MODEL NO. STATE: PROCESS

STATUS: NORMAL

DATE: 11/23/07

WEEKEND PRODUCTION RATE: 1.00 LB/WT

LAST 600 LEVEL: 3

W1904-1 1.795 0

W1904-2 1.791 0

W1904-3 1.786 0

W1904-4 1.785 0

W1904-5 1.772 0

W1904-6 1.770 0

W1904-7 1.670 0

W1904-8 1.664 0

W1904-9 1.624 0

W1904-10 1.606 0

W1904-11 1.510 0

W1904-12 1.450 0

CELLING 1.423 0

QUALITY: OFFICE

PAGE 2 OF 2

(F1) DATE

(F2) SUBMITTER NAME

(F3) DATE RECEIVED

(F4) DATE OFFER

(F5) DATE LOGGING

(F6) DATE OFFER

(F7) DATE LOGGING

(F8) DATE OFFER

(F9) DATE LOGGING

(F10) DATE OFFER

(F11) DATE LOGGING

(F12) DATE OFFER

(F13) DATE LOGGING

(F14) DATE OFFER

(F15) DATE LOGGING

(F16) DATE OFFER

(F17) DATE LOGGING

(F18) DATE OFFER

(F19) DATE LOGGING

(F20) DATE OFFER

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(F23) DATE LOGGING

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(F94) DATE OFFER

(F95) DATE LOGGING

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(F97) DATE LOGGING

(F98) DATE OFFER

(F99) DATE LOGGING

(F100) DATE OFFER

2171 2011 09 15 1515

[illegible]

BUTENM PRODUCTION DATE: 0.00 (0/DAY)
 HYDROGEN PRODUCTION DATE: 0.00 (0/DAY)
 OPERATING TIME: 94.4 hours

175427 967 4507
37.1 grams
2011/01/17/24

WISD 51 1-7026 JMD 1-909A37 RINW6/27113 E014

1985-1 9817
 1985-2 9818
 1985-3 9819
 1985-4 9820
 1985-5 9821
 1985-6 9822
 1985-7 9823
 1985-8 9824
 1985-9 9825
 1985-10 9826
 1985-11 9827
 1985-12 9828

7706-2 17 PSIA

[illegible]

PAGE 6

THE

00000-76-119

66-438-92 1319
M011782029 839180 36517
JAN 09 1961

OF: 00
 STATE: PA
 COUNTY: 00
 CITY: 00
 ZIP: 00
 PHONE: 00-00000000
 FAX: 00-00000000
 E-MAIL: 00@00.00

UNITED STATES: INTERNAL

TIGER PRODUCTION DATE: 6 AA 10-04

[illegible][illegible]

200 1-767A3V, 3M/06/27713 3000
 177A37 000 1000 0000 0000

[illegible]

9905-1 VENT
9905-2 OFF
9905-3 17 PSIA

0005-2 WEST
LEWIS-3 OFF
P704-3 29 PS10

035013 1-150A
NO 0-900A37
0120 05 6 00246
RSCA R2 F-00/4

035012 2-150A	NO 4-000071	88779	2.59 P310
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[illegible]

0154 0 1-68144
9739-1 0 9310
150 9-90927
08106-6 081

035012 1 180A
430 6-709A17
6154 1 6-66A40
027001 1 180A

5184 1 5:46:40

(12) SUBSISIDR PARA	(13) RUMAL ORER	(14) DATA LOGGING	PAGE 1 OF 2																									
(15) NAME SELECTION	(16) VIEW ORER	(17) EDIT																										
26-SEP-74 09:16:10 500 PMSSE	0.00	0.00	32.3	4	0.149	14	17	23	25	25.1	0.00	0	3	79	79	0.36	12.6	13.9	-1	1.144	1.161	1.162	1.148	0.001	0.010	0.004	0.020	0.017
26-SEP-74 09:17:00 500 PMSSE	0.00	0.00	33.1	6	0.151	15	21	23	24.0	0.00	1	6	79	79	0.30	12.3	13.9	-1	1.143	1.145	1.145	1.144	0.004	0.012	0.009	0.008	0.013	
26-SEP-74 09:18:10 500 PMSSE	0.00	0.00	33.1	3	0.151	15	21	24	2.37	0.00	1	6	79	79	0.32	12.4	13.9	-1	1.142	1.145	1.145	1.144	0.003	0.015	0.004	0.012	0.024	

[illegible]

HYDROGEN PRODUCTION RATE: 0.00 LB/DAY

OPERATING TIME	33.3 HOURS	LAST JOB LEVEL	3
0003 FULL-LOADING	LE0004-1 OFF	0706-1	10 PS10
0005-1 RUN	LE0004-2 OFF	0706-2	22 PS10
0005-2 RUN	LE0004-3 OFF	0706-3	25 PS10
0031-1 CLOSED	LE0004-4 OFF	0709	2.53 PS10
0031-2 OPEN	LE0005-1 OFF	0709	0.00 PS10
0033 CLOSED	LE0006-1 OFF	0710-1	9 PS10
0001-1 CLOSED	LE0006-2 OFF	0710-2	7 PS10
0001-2 CLOSED	0709-3 OFF	1702-1	70 F
0001-3 CLOSED	0709-3 OFF	1702-2	80 F
0001-4 CLOSED	0709-3 OFF	1702-3	80 F
0002 OFF	LE0005-1	12.6 CM	10
0003 OFF	LE0005-2	15.9 CM	10
0004 OFF	0713	12 PS15	

133140
:170000

(011) PAGE	(103) COWIN CHECK	(173) ACCOUNT/LEASE	(181) MONTH AFTER
(172) VERIFICATION PANA	(175) MANUAL AFTER	(180) DATA LOGGING	
(173) WORK SELECTION	(183) VIEW AFTER	(191) EDIT	PAGE 1 OF 2
70-507-01 0121010 500 PARGE		0.00 0.00 33.1	0.1
70-507-01 0121010 500 PARGE		0.00 0.00 33.1	0.1
DATE: 70-507-01	LEAD: 01210107		

(F3) MODE SELECTION
 (F6) VIEW OPER
 (F9) EXIT

[illegible]

TECHN PRODUCTION DATE: 0.40 LD/DAY HIRSHFELD PRODUCTION DATE: 0.96 19/JAY

Y003	FILLZ/PRIENT	LE0000-1 DEF	Y000-1	13	P510
Y000-1 Y000	LE0000-2 DEF	Y000-2 <td>33 <td>P510</td> <td></td> </td>	33 <td>P510</td> <td></td>	P510	
Y000-1 Y000	LE0000-3 DEF	Y000-3 <td>23 <td>P510</td> <td></td> </td>	23 <td>P510</td> <td></td>	P510	
Y001-1 CL0500	LE0000-4 DEF	Y000	2.04 <td>P510</td> <td></td>	P510	
Y001-2 CL0500	LE0000-5 DEF	Y000	0.00 <td>P510</td> <td></td>	P510	
Y001-3 CL0500	LE0000-6 DEF	Y000-1	31	P510	
Y001-2 CL0500	LE0000-7 DEF	Y000-2	37	P510	
Y001-3 CL0500	Y000705 DEF	Y102-1	00	F	
Y001-4 CL0500	CAC0705 0.10 QM	Y102-2	00	F	
Y00022 DEF	LE0000-1 12.4 CV IN	Y206-1	70	F	
Y00043 DEF	LE0000-2 13.9 CV IN	Y103	4	P510	

ADVICE:

[illegible]

24 SEP 94 01:31:00 500 PROCESS	11.27	1.00	33.2	4	1.007	175	174	101	2.52	5.35	45	17	114	01	0.43	12.5	13.0	40	1.015	1.022	1.022	1.022	1.010	1.107	0.275	0.205	0.202	0.201	0.020
24 SEP 94 01:31:00 500 PROCESS	11.27	1.00	33.2	4	1.007	175	174	101	2.52	5.35	45	17	114	01	0.43	12.5	13.0	40	1.015	1.022	1.022	1.022	1.010	1.107	0.275	0.205	0.202	0.201	0.020
24 SEP 94 01:31:00 500 PROCESS	11.27	1.00	33.2	4	1.007	175	174	101	2.52	5.35	45	17	114	01	0.43	12.5	13.0	40	1.015	1.022	1.022	1.022	1.010	1.107	0.275	0.205	0.202	0.201	0.020
24 SEP 94 01:31:00 500 PROCESS	11.27	1.00	33.2	4	1.007	175	174	101	2.52	5.35	45	17	114	01	0.43	12.5	13.0	40	1.015	1.022	1.022	1.022	1.010	1.107	0.275	0.205	0.202	0.201	0.020
24 SEP 94 10:00:00 500 OFF	11.27	1.00	33.2	4	0.000	16	10	16	0.16	0.00	4	2	00	01	0.00	10.0	13.0	0	0.713	0.701	0.701	0.701	0.416	0.970	0.010	0.000	0.001	0.002	0.010
24 SEP 94 11:01:00 501 OFF	0.00	0.00	33.2	4	0.000	16	17	16	0.30	0.00	5	2	00	03	0.00	10.0	13.0	-0	0.710	0.700	0.700	0.700	0.439	0.907	0.009	0.002	0.002	0.031	0.015

24 SEP 74 11:12:05 500 PROCESS 11.20 1.41 33.2 3 1.002 177 100 100 2.50 5.10 65 15 110 00 0.30 12.6 11.4 60 0.709 1.002 0.370 1.000 1.100 0.300 0.270 0.320 0.322 0.429

DATE: 24 SEP 74 LEAVE OTHER GENERATION TIME: 11:12:00
MODE: OM STATE: PROCESS STATUS: NORMAL

OTHER PRODUCTION DATES: 11.20 10/74/74 THROUGH PRODUCTION DATE: 1.41 10/74/74
OPERATING TIME: 33.2 HOURS LAST 400 LEVEL: 3

W03 FILL/HEATING LEV000-1 OFF P700-1 177 PSIA
W03-1 PARAMET LEV000-2 OFF P700-2 104 PSIA
W03-2 PRODUCT LEV000-3 OFF P700-3 103 PSIA
W03-1 CLOSED LEV000-4 OFF P700 2.57 PSID
W03-2 CLOSED LEV000-5 OFF P700 5.04 PSID
W03 CLOSED LEV000-6 OFF P700-1 65 PSID
W03-1 CLOSED LEV000-7 OFF P700-2 15 PSID
W03-2 OPEN P0705 ON 102-1 107 F
W03-1 CLOSED 102-2 107 F
W03-1 CLOSED 102-3 105 F
C00705 0.41 GPH 102-4 85 F
C00705-1 12.4 CM IN 102-5 84 F
P0703 ON P0704 2 11.4 CM IN P713 172 PSIS
P0704 ON

ANNUAL:
OFFICE:

(F1) PAGE (F4) COME IN CTRL (F7) ACKNOWLEDGE (F10) MODIFY OPER
(F2) SUBSTITUTION PARA (F5) MANUAL OPER (F6) DATA LOGGING
(F3) MODE SELECTION (F8) VIEW OPER (F9) EXIT PAGE 1 OF 2

DATE: 24 SEP 74 LEAVE OTHER GENERATION TIME: 11:12:00
MODE: OM STATE: PROCESS STATUS: NORMAL

OTHER PRODUCTION DATES: 11.10 10/74/74 THROUGH PRODUCTION DATE: 1.39 10/74/74
OPERATING TIME: 33.2 HOURS LAST 400 LEVEL: 3

C0700-1 -1 2 LEL 027700-1 0.999 V W1900-1 1.003 V
C0700-2 -0 2 LEL 027700-2 1.002 V W1900-2 1.003 V
C0700-3 -0 2 LEL 027700-3 0.999 V W1900-3 1.002 V
C0700-4 -1 2 LEL 027700-4 0.999 V W1900-4 1.700 V
C0705 0.0 MM/CM 027700 1.154 V W1900-5 1.700 V
1700 60 MPS 027705 1.020 V W1900-6 1.003 V
1700-1 0.333 A W1900-7 1.009 V
1700-2 0.274 A W1900-8 1.009 V
1700-3 0.224 A W1900-9 1.009 V
1700-4 0.224 A W1900-10 1.010 V
1700 0.334 A W1900-11 1.703 V
1700 0.334 A W1900-12 1.070 V
CELL006 1.000 V

ANNUAL:
OFFICE:

(F1) PAGE (F4) COME IN CTRL (F7) ACKNOWLEDGE (F10) MODIFY OPER
(F2) SUBSTITUTION PARA (F5) MANUAL OPER (F6) DATA LOGGING
(F3) MODE SELECTION (F8) VIEW OPER (F9) EXIT PAGE 2 OF 2

24 SEP 74 11:12:05 500 PROCESS 11.21 1.40 33.2 4 1.034 175 104 101 2.50 6.02 64 17 110 06 0.43 15.1 11.3 60 1.002 0.370 0.370 1.000 1.100 0.300 0.277 0.322 0.321 0.423
24 SEP 74 11:12:05 500 PROCESS 11.27 1.41 33.2 3 1.033 176 104 100 2.57 5.50 64 16 110 06 0.40 15.2 13.0 60 1.001 0.369 1.001 0.369 1.100 0.310 0.277 0.322 0.319 0.427
24 SEP 74 11:12:05 500 PROCESS 11.26 1.40 33.3 3 1.030 176 104 129 2.65 4.92 64 10 110 06 0.43 15.2 15.2 60 0.999 1.002 0.999 1.000 1.100 0.310 0.280 0.324 0.327 0.409
24 SEP 74 11:12:05 500 PROCESS 11.24 1.40 33.3 3 1.027 176 104 100 2.60 4.40 64 10 110 06 0.42 15.1 15.2 60 0.999 0.999 0.999 1.000 1.100 0.317 0.275 0.320 0.325 0.416
24 SEP 74 11:12:05 500 PROCESS 11.24 1.40 33.3 2 1.033 176 104 101 2.63 5.50 64 16 110 06 0.43 15.1 12.4 60 0.999 0.993 0.999 1.001 1.101 0.316 0.271 0.320 0.324 0.432
24 SEP 74 11:12:05 500 PROCESS 11.21 1.40 33.3 2 1.009 177 105 103 2.70 5.32 64 15 115 06 0.42 12.4 10.0 60 0.999 0.991 0.999 1.001 1.103 0.300 0.269 0.320 0.320 0.406
24 SEP 74 11:12:05 500 PROCESS 11.24 1.40 33.3 3 1.041 176 104 100 2.65 5.20 64 17 110 07 0.40 12.6 12.4 60 0.999 0.993 0.999 1.000 1.104 0.315 0.275 0.322 0.324 0.410
24 SEP 74 11:12:05 500 PROCESS 11.29 1.41 33.3 3 1.039 176 105 100 2.60 4.92 64 10 117 07 0.42 13.0 15.1 60 0.999 0.990 0.999 1.000 1.100 0.317 0.277 0.324 0.322 0.429
24 SEP 74 11:12:05 500 PROCESS 11.27 1.41 33.3 3 1.036 176 105 100 2.60 4.70 64 10 117 07 0.42 15.1 12.6 60 0.994 0.990 0.999 1.000 1.104 0.316 0.267 0.324 0.324 0.426
24 SEP 74 11:12:05 500 PROCESS 11.20 1.41 33.4 3 1.033 176 105 100 2.60 5.07 64 17 110 07 0.40 15.2 10.1 60 0.987 0.993 0.999 1.003 1.101 0.315 0.266 0.320 0.320 0.437
24 SEP 74 11:12:05 500 240PT55 11.29 1.41 33.4 4 1.029 174 104 101 2.65 5.27 64 16 110 07 0.40 15.2 11.3 60 0.993 0.995 0.995 1.000 1.102 0.323 0.269 0.324 0.324 0.439

A-54

24-SEP-94 15:04:10 500 PWRSE	0.00	0.00	34.4	7	1.371	15	10	14	0.00	0.00	2	3	107	99	0.00	15.1	15.2	-0	1.377	1.123	1.175	1.172	1.132	0.035	0.332	0.038	0.971	0.031
24-SEP-94 15:04:10 500 WFT	0.00	0.00	34.4	7	0.000	04	17	16	0.20	0.00	4	2	101	99	0.00	15.9	15.2	-0	1.432	1.021	1.021	1.021	1.022	0.000	0.001	0.001	0.010	0.015
24-SEP-94 15:04:10 500 PWRSE	0.00	0.00	34.4	4	1.276	15	17	28	3.05	0.00	5	3	103	100	0.30	12.4	15.1	-0	1.176	1.179	1.102	1.170	1.103	0.025	0.029	0.026	0.010	0.024
24-SEP-94 15:04:10 500 PWRSE	0.00	0.00	34.4	5	1.117	15	17	25	2.91	0.00	4	3	103	99	0.39	12.4	15.1	-0	1.195	1.199	1.109	1.109	1.110	0.017	0.010	0.020	0.055	0.032
24-SEP-94 15:04:10 500 PWRSE	0.00	0.00	34.4	3	0.990	15	20	25	2.76	0.00	17	14	102	99	0.38	12.4	15.2	-0	1.199	1.194	1.102	1.102	1.137	0.015	0.010	0.013	0.045	0.000

DATE: 24-SEP-94 LEVPE OUTGEN GENERATION TIME: 15:22:00
MODE: ON STATUS: NORMAL

OUTGEN PRODUCTION DATE: 0.00 10/04/94 OUTGEN PRODUCTION DATE: 0.00 10/04/94

OPERATING TIME: 34.4 HOURS LAST 000 LEVEL: 3

W001 FULL/PAUSE	LEV000-1 WFT	P700-1 10 PS10
W002-1 WFT	LEV000-2 WFT	P700-2 07 PS10
W003-2 WFT	LEV000-3 WFT	P700-3 25 PS10
W004-1 CLOSED	LEV000-4 WFT	00700 2.71 PS10
W005-2 WFT	LEV000-5 WFT	00700 0.00 PS10
W006 CLOSED	LEV000-6 WFT	00700-1 30 PS10
W007-1 CLOSED	LEV000-7 WFT	00700-2 32 PS10
W008-2 CLOSED	P00705 WFT	1702-1 101 F
W009-3 CLOSED		1702-2 101 F
W010-4 CLOSED	CMC2705 0.35 070	1720-1 99 F
W011-5 CLOSED	LEV000-1 12.5 CM 10	1730-2 101 F
W012 WFT	LEV000-2 15.1 CM 10	P710 13 PS10
W013 ON		
W014 WFT		

ANNUALTY:
ARTICLE:

(11) PAGE (14) CMC2705 CONTROL (17) ACKNOWLEDGE (110) MODIFY OPEN
(12) SUBSTITUTION PANA (15) RUNNING OPEN (10) DATA LOGGING
(13) MORE SELECTION (16) VIEW OPEN (17) EXIT PAGE 1 OF 2

DATE: 24-SEP-94 LEVPE OUTGEN GENERATION TIME: 15:23:15
MODE: ON STATUS: NORMAL

OUTGEN PRODUCTION DATE: 1.32 10/04/94 OUTGEN PRODUCTION DATE: 0.10 10/04/94

OPERATING TIME: 34.4 HOURS LAST 000 LEVEL: 4

W001 FULL/PAUSE	LEV000-1 WFT	P700-1 10 PS10
W002-1 WFT	LEV000-2 WFT	P700-2 32 PS10
W003-2 WFT	LEV000-3 WFT	P700-3 22 PS10
W004-1 CLOSED	LEV000-4 WFT	00700 2.10 PS10
W005-2 WFT	LEV000-5 WFT	00700 0.72 PS10
W006 CLOSED	LEV000-6 WFT	00700-1 01 PS10
W007-1 CLOSED	LEV000-7 WFT	00700-2 37 PS10
W008-2 CLOSED	P00705 ON	1702-1 101 F
W009-3 CLOSED		1720-1 99 F
W010-4 CLOSED	CMC2705 0.24 070	1730-1 99 F
W011-5 CLOSED	LEV000-1 7.4 CM 10	1730-2 101 F
W012 WFT	LEV000-2 15.1 CM 10	P710 9 PS10
W013 ON		
W014 WFT		

ANNUALTY:
ARTICLE:

(11) PAGE (14) CMC2705 CONTROL (17) ACKNOWLEDGE (110) MODIFY OPEN
(12) SUBSTITUTION PANA (15) RUNNING OPEN (10) DATA LOGGING
(13) MORE SELECTION (16) VIEW OPEN (17) EXIT PAGE 1 OF 2

24-SEP-94 15:24:00 500 PWRSE	0.00	0.00	34.4	4	1.710	31	07	37	2.13	1.30	07	34	101	99	0.01	7.5	15.1	41	1.102	1.100	1.122	1.120	1.130	0.004	0.001	0.003	0.051	0.000
24-SEP-94 15:24:00 500 PWRSE	0.00	0.00	34.4	4	1.022	50	70	34	2.32	2.06	55	27	104	99	0.01	7.5	15.1	00	1.138	1.106	1.101	1.100	1.104	0.025	0.029	0.030	0.070	0.002
24-SEP-94 15:24:00 500 PWRSE	0.00	0.00	34.4	3	1.001	40	09	73	2.41	1.07	59	19	105	99	0.03	7.4	15.2	00	1.172	1.107	1.175	1.170	1.139	0.039	0.031	0.039	0.070	0.009
24-SEP-94 15:24:00 500 PWRSE	0.00	0.00	34.4	3	1.005	09	90	75	2.39	1.00	40	20	104	99	0.39	7.5	15.2	00	1.170	1.075	1.075	1.075	1.131	0.034	0.009	0.049	0.077	0.009

31015 MONY 2011 3100
MO1172029 R39110 345J

[illegible]

GEN PRODUCTION RATE: 0.00 LB/DAY HYDROGEN PRODUCTION RATE: 0.00 LB/DAY
 CATALYSTING TIME: 34.6 HOURS TEST FOR LEVEL: 9

UNJ FILE2/00A/001 07406-1 003 0707-1 10 0010

[illegible]

PAGE 7 OF 8

DISC #2 E-9064

LEVINSON, J. MICHAEL

1978-7-6001

0343 1-1564
0800 0-90000
0134 072 68781

001-2-1504 1741-9-06

[illegible]

0154 2 1-80/48
480 0-000000
1200 7/00

0551 1 2-0164
JMB 1-907837
03077 1-104

1001-2 21053 1772-1 10 6

1981-3 11053

11/ 2-20/11

1-9661 828 65'0 64/37M9 0307M 4-1000

1 86 2-9661
MI 03 0-71 1-607431
480 224074

PM2103 008	LE603-2 14.0 00 14	2217	12 DEC 19
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Page 11

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IM

1

4500

PAGE [F4] CONT'D CTRL [F7] ACTNOWLEDGE [F10] MODIFY OPER

SUBSYSTEM PARA (FS) BANCAL OPER (FS) DATA LOGGING

DATE	DESCRIPTION	AMOUNT	BALANCE
1991 01 01	OPENING BALANCE	100.00	100.00
1991 01 15	PAYROLL	50.00	50.00
1991 01 31	CLOSING BALANCE	50.00	50.00

0-00 00-17-30 100 000000

Time	Location	Temperature	Humidity	Wind Speed	Wind Direction	Cloud Cover	Visibility	Pressure	Notes
08:00	Field Station	22.0	65%	1.5	SE	10%	10 km	1013.2	Clear sky
09:00	Field Station	24.5	60%	2.0	SE	15%	10 km	1013.0	Light breeze
10:00	Field Station	26.0	55%	2.5	SE	20%	10 km	1012.8	Increasing cloud
11:00	Field Station	27.5	50%	3.0	SE	30%	10 km	1012.5	Clouds building
12:00	Field Station	29.0	45%	3.5	SE	40%	10 km	1012.2	Thunder possible
13:00	Field Station	30.5	40%	4.0	SE	50%	10 km	1012.0	Thunder started
14:00	Field Station	32.0	35%	4.5	SE	60%	10 km	1011.8	Heavy rain
15:00	Field Station	33.5	30%	5.0	SE	70%	10 km	1011.5	Thunder continued
16:00	Field Station	35.0	25%	5.5	SE	80%	10 km	1011.2	Very heavy rain
17:00	Field Station	36.5	20%	6.0	SE	90%	10 km	1011.0	Thunderstorm peak
18:00	Field Station	38.0	15%	6.5	SE	100%	10 km	1010.8	Thunderstorm peak
19:00	Field Station	39.5	10%	7.0	SE	100%	10 km	1010.5	Thunderstorm peak
20:00	Field Station	41.0	5%	7.5	SE	100%	10 km	1010.2	Thunderstorm peak
21:00	Field Station	42.5	0%	8.0	SE	100%	10 km	1010.0	Thunderstorm peak
22:00	Field Station	44.0	0%	8.5	SE	100%	10 km	1009.8	Thunderstorm peak
23:00	Field Station	45.5	0%	9.0	SE	100%	10 km	1009.5	Thunderstorm peak
00:00	Field Station	47.0	0%	9.5	SE	100%	10 km	1009.2	Thunderstorm peak
01:00	Field Station	48.5	0%	10.0	SE	100%	10 km	1009.0	Thunderstorm peak
02:00	Field Station	50.0	0%	10.5	SE	100%	10 km	1008.8	Thunderstorm peak
03:00	Field Station	51.5	0%	11.0	SE	100%	10 km	1008.5	Thunderstorm peak
04:00	Field Station	53.0	0%	11.5	SE	100%	10 km	1008.2	Thunderstorm peak
05:00	Field Station	54.5	0%	12.0	SE	100%	10 km	1008.0	Thunderstorm peak
06:00	Field Station	56.0	0%	12.5	SE	100%	10 km	1007.8	Thunderstorm peak
07:00	Field Station	57.5	0%	13.0	SE	100%	10 km	1007.5	Thunderstorm peak
08:00	Field Station	59.0	0%	13.5	SE	100%	10 km	1007.2	Thunderstorm peak
09:00	Field Station	60.5	0%	14.0	SE	100%	10 km	1007.0	Thunderstorm peak
10:00	Field Station	62.0	0%	14.5	SE	100%	10 km	1006.8	Thunderstorm peak
11:00	Field Station	63.5	0%	15.0	SE	100%	10 km	1006.5	Thunderstorm peak
12:00	Field Station	65.0	0%	15.5	SE	100%	10 km	1006.2	Thunderstorm peak
13:00	Field Station	66.5	0%	16.0	SE	100%	10 km	1006.0	Thunderstorm peak
14:00	Field Station	68.0	0%	16.5	SE	100%	10 km	1005.8	Thunderstorm peak
15:00	Field Station	69.5	0%	17.0	SE	100%	10 km	1005.5	Thunderstorm peak
16:00	Field Station	71.0	0%	17.5	SE	100%	10 km	1005.2	Thunderstorm peak
17:00	Field Station	72.5	0%	18.0	SE	100%	10 km	1005.0	Thunderstorm peak
18:00	Field Station	74.0	0%	18.5	SE	100%	10 km	1004.8	Thunderstorm peak
19:00	Field Station	75.5	0%	19.0	SE	100%	10 km	1004.5	Thunderstorm peak
20:00	Field Station	77.0	0%	19.5	SE	100%	10 km	1004.2	Thunderstorm peak
21:00	Field Station	78.5	0%	20.0	SE	100%	10 km	1004.0	Thunderstorm peak
22:00	Field Station	80.0	0%	20.5	SE	100%	10 km	1003.8	Thunderstorm peak
23:00	Field Station	81.5	0%	21.0	SE	100%	10 km	1003.5	Thunderstorm peak
00:00	Field Station	83.0	0%	21.5	SE	100			

[illegible]

2-14 00:15:20 500 PURSC 0.00 0.00 34.4

2-94 00:16:20 500 PWRGE

[illegible][illegible]

15403 CH 2:56:56 01.0

27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	6	0.702	15	17	17	0.10	0.00	5	2	76	77	0.00	10.4	15.2	-0	1.193	1.190	1.106	1.135	0.00	0.017	0.015	0.005	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	7	0.700	15	17	20	2.00	0.00	5	2	76	77	0.35	13.9	15.2	-0	1.180	1.197	1.106	1.139	0.013	0.013	0.010	0.001	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	8	0.707	15	17	27	2.37	0.00	5	2	76	77	0.32	13.9	15.2	-0	1.192	1.100	1.106	1.133	0.012	0.017	0.015	0.005	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	9	0.700	15	17	27	2.00	0.00	5	2	76	77	0.32	13.9	15.2	-0	1.195	1.192	1.106	1.109	0.011	0.011	0.015	0.009	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	6	0.701	15	17	27	2.32	0.00	5	2	76	77	0.35	13.9	15.1	-0	1.187	1.199	1.106	1.131	0.013	0.013	0.012	0.003	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	6	0.706	15	17	26	2.32	0.00	5	2	76	77	0.35	13.9	15.1	-0	1.187	1.186	1.107	1.135	0.006	0.007	0.015	0.003	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	6	0.706	15	17	26	2.32	0.00	5	2	76	77	0.35	13.9	15.2	-0	1.189	1.195	1.107	1.135	0.015	0.013	0.011	0.006	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	6	0.701	15	17	26	2.32	0.00	5	2	76	77	0.32	13.9	15.1	-0	1.184	1.192	1.107	1.133	0.011	0.012	0.015	0.005	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	6	0.701	15	17	26	2.30	0.00	5	2	76	77	0.32	13.9	15.1	-0	1.187	1.197	1.107	1.133	0.004	0.012	0.015	0.005	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	5	0.716	15	17	25	2.37	0.00	5	2	76	77	0.36	13.9	15.1	-0	1.180	1.190	1.106	1.109	0.011	0.011	0.012	0.003	0.000
27-SEP-94 01:20:10 500 PWRGE	0.00	0.00	0.0	5	0.716	15	17	25	2.37	0.00	5	2	77	77	0.30	13.9	15.2	-0	1.190	1.106	1.106	1.103	0.007	0.000	0.011	0.007	0.000

DATE: 27-SEP-94 TIME: 01:20:47
MODE: ON STATE: PWRGE STATUS: NORMAL

OUTER PRODUCTION RATE: 0.00 LB/DAY THROUGH PRODUCTION RATE: 0.00 LB/DAY

OPERATING TIME: 0.0 HOURS LAST 400 LEVEL: 4

0003 FULLY/PWRGE LEV000-1 OFF P700-1 15 PSIA

0003-1 WRT LEV000-2 OFF P700-2 17 PSIA

0003-2 WRT LEV000-3 OFF P700-3 25 PSIA

0003-3 WRT LEV000-4 ON P700 2.42 PSID

0003-1 CLOSED LEV000-5 OFF P700 0.00 PSID

0003-2 CLOSED LEV000-6 OFF P700-1 5 PSID

0003 WRT LEV000-7 OFF P700-2 2 PSID

0003-1 CLOSED P00705 OFF P702-1 77 F

0003-2 CLOSED P00705 OFF P702-2 77 F

0003-3 CLOSED P00705 OFF P702-3 77 F

0003-4 CLOSED P00705 OFF P702-4 77 F

0003-5 CLOSED P00705 OFF P702-5 77 F

0003-6 CLOSED P00705 OFF P702-6 77 F

0003-7 CLOSED P00705 OFF P702-7 77 F

0003-8 CLOSED P00705 OFF P702-8 77 F

0003-9 CLOSED P00705 OFF P702-9 77 F

0003-10 CLOSED P00705 OFF P702-10 77 F

0003-11 CLOSED P00705 OFF P702-11 77 F

0003-12 CLOSED P00705 OFF P702-12 77 F

0003-13 CLOSED P00705 OFF P702-13 77 F

0003-14 CLOSED P00705 OFF P702-14 77 F

0003-15 CLOSED P00705 OFF P702-15 77 F

0003-16 CLOSED P00705 OFF P702-16 77 F

0003-17 CLOSED P00705 OFF P702-17 77 F

0003-18 CLOSED P00705 OFF P702-18 77 F

0003-19 CLOSED P00705 OFF P702-19 77 F

0003-20 CLOSED P00705 OFF P702-20 77 F

0003-21 CLOSED P00705 OFF P702-21 77 F

0003-22 CLOSED P00705 OFF P702-22 77 F

0003-23 CLOSED P00705 OFF P702-23 77 F

0003-24 CLOSED P00705 OFF P702-24 77 F

0003-25 CLOSED P00705 OFF P702-25 77 F

0003-26 CLOSED P00705 OFF P702-26 77 F

0003-27 CLOSED P00705 OFF P702-27 77 F

0003-28 CLOSED P00705 OFF P702-28 77 F

0003-29 CLOSED P00705 OFF P702-29 77 F

0003-30 CLOSED P00705 OFF P702-30 77 F

0003-31 CLOSED P00705 OFF P702-31 77 F

0003-32 CLOSED P00705 OFF P702-32 77 F

0003-33 CLOSED P00705 OFF P702-33 77 F

0003-34 CLOSED P00705 OFF P702-34 77 F

0003-35 CLOSED P00705 OFF P702-35 77 F

0003-36 CLOSED P00705 OFF P702-36 77 F

0003-37 CLOSED P00705 OFF P702-37 77 F

0003-38 CLOSED P00705 OFF P702-38 77 F

0003-39 CLOSED P00705 OFF P702-39 77 F

0003-40 CLOSED P00705 OFF P702-40 77 F

0003-41 CLOSED P00705 OFF P702-41 77 F

0003-42 CLOSED P00705 OFF P702-42 77 F

0003-43 CLOSED P00705 OFF P702-43 77 F

0003-44 CLOSED P00705 OFF P702-44 77 F

0003-45 CLOSED P00705 OFF P702-45 77 F

0003-46 CLOSED P00705 OFF P702-46 77 F

0003-47 CLOSED P00705 OFF P702-47 77 F

A-62

A-64

[illegible]

HYDROGEN PRODUCTION RATE, 15.00 L/UNIT	HYDROGEN PRODUCTION RATE, 1.47 L/UNIT
OPERATING TIME	LAST 40 LEVELS
CS304-1	2.5 L/CEL
CS304-2	-1 3 L/CEL
CS304-3	3 L/CEL
CS304-4	3 L/CEL
CS304-5	-1 3 L/CEL
CS305	0.0 WH/0.028
1744	79 AMP\$
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	1.027 A
1744	1.910 A
CS304-1	0.403 A
CS304-2	2.133 A
CS304-3	1.122 A
CS304-4	1.134 A
CS304-5	1.154 A
CS305	

(F1) PAGE	(F2) SUBSTITUTED PAM	(F3) NAME AFTER	(F4) COW'S CTRAL	(F5) DATA LOGGING	(F6) ACCOUNT NUMBER	(F7) INDENT OFFER
27-527-14 1321610	500 P000555	27-527-14 1321610	500 P000555	15.42	1.07	2.4
27-527-14 1321613	500 P000555	27-527-14 1321613	500 P000555	15.49	1.07	2.4
27-527-14 1321615	500 P000555	27-527-14 1321615	500 P000555	15.49	1.07	2.4
27-527-14 1321616	500 P000555	27-527-14 1321616	500 P000555	15.49	1.06	2.5
27-527-14 1321618	500 P000555	27-527-14 1321618	500 P000555	15.02	1.07	2.3
27-527-14 1321619	500 P000555	27-527-14 1321619	500 P000555	15.01	1.07	2.5

UNIT/REP PRODUCTION RATE: 16.95 LBS/UNIT	DIFFERENCE PRODUCTION RATE: 1.04 LBS/UNIT
OPERATION TIME: 2.5 HOURS <td>LAST AOD LEVEL: 3 </td>	LAST AOD LEVEL: 3
CP746-1 -2 2 LEL	CP746-1 0.409 V
CP746-2 -0 2 LEL	CP746-2 1.031 V
CP746-3 -0 2 LEL	CP746-3 1.172 V
CP746-4 -1 2 LEL	CP746-4 1.020 V
CP335 0.0 MM/CM	CP746-5 1.010 V
1746 79 MPS	CP746-6 1.031 V
	CP746-7 1.013 V
	CP746-8 1.100 V
	CP746-9 1.061 V
	CP746-10 1.051 V
	CP746-11 1.097 V
	CP746-12 1.040 V

ANNUALTY:
ARTICLE:

(F1) PAGE (F4) COMFIO CRUI (F7) ACUMPCENGE (F10) MODITY OPER
(F2) SUBSISTEN PAMA (F5) DMMAL OPER (F6) MATA LONGING
(F3) MORE SELECTION (F4) VIEW OPER (F9) EDIT PAGE 2 OF 2
27-SEP-94 13:21:05 500 PROCESS 14.95 1.46 2.5 3 1.002 01 102 00 2.97 0.40 59 19 110 76 0.43 17.4 11.5 79 0.418 1.136 1.129 1.120 1.004 0.127 0.099 0.116 0.102 0.000
27-SEP-94 13:27:05 500 PROCESS 14.95 1.46 2.5 3 1.006 02 102 00 2.97 0.40 59 19 110 76 0.39 26.1 11.4 79 0.410 1.132 1.132 1.125 1.008 0.127 0.105 0.128 0.103 0.000
27-SEP-94 13:28:05 500 PROCESS 15.00 1.07 2.5 2 1.001 03 102 00 2.91 0.35 59 17 110 97 0.44 16.9 11.3 79 0.416 1.116 1.121 1.110 1.130 0.130 0.109 0.132 0.102 0.000
27-SEP-94 13:29:05 500 PROCESS 14.96 1.07 2.5 3 1.005 04 102 01 2.94 0.39 59 16 113 76 0.41 15.0 11.9 79 0.416 1.136 1.131 1.123 1.100 0.130 0.107 0.132 0.103 0.000
27-SEP-94 13:30:05 500 PROCESS 15.03 1.07 2.6 3 1.007 04 102 02 2.93 0.41 59 16 115 76 0.40 16.1 11.1 79 0.418 1.126 1.132 1.123 1.103 0.132 0.099 0.107 0.105 0.000
27-SEP-94 13:31:05 500 PROCESS 15.00 1.07 2.6 4 1.004 03 102 00 2.96 0.40 59 17 117 97 0.42 12.5 11.3 79 0.407 1.134 1.131 1.120 1.107 0.136 0.099 0.115 0.100 0.000
27-SEP-94 13:32:05 500 PROCESS 14.97 1.07 2.6 4 1.003 02 102 00 2.95 0.39 59 19 119 76 0.42 13.9 11.3 79 0.416 1.132 1.128 1.122 1.102 0.128 0.094 0.110 0.100 0.000

DATE: 27-SEP-94 USPE DUTCH REGISTRATION TIME: 13:32:12
MODE: ON STATE: PROCESS STATUS: NORMAL

BITEN PRODUCTION RATE: 14.97 L/D/AT WITNESS PRODUCTION RATE: 1.07 L/D/AT

OPERATING TIME: 2.6 HOURS LAST 404 LEVEL: 4

CE740-1 -2 8 LCL 029700-1 0.615 V W1900-1 1.994 V
CE740-2 -0 8 LCL 029700-2 1.131 V W1900-2 1.037 V
CE740-3 -0 8 LCL 029700-3 1.123 V W1900-3 1.039 V
CE740-4 -1 8 LCL 029700-4 1.122 V W1900-4 1.036 V
CE755 0.0 MMH/CH 029900 1.100 V W1900-5 1.012 V
1204 79 AMPS 029900 1.027 V W1900-6 1.023 V
W1900-7 1.939 V
W1900-8 1.707 V
W1900-9 1.033 V
W1900-10 1.007 V
W1900-11 1.904 V
W1900-12 1.007 V
CELLS: 1.002 V

ANNUALTY:
ARTICLE:

(F1) PAGE (F4) COMFIO CRUI (F7) ACUMPCENGE (F10) MODITY OPER
(F2) SUBSISTEN PAMA (F5) DMMAL OPER (F6) MATA LONGING
(F3) MORE SELECTION (F4) VIEW OPER (F9) EDIT PAGE 2 OF 2
27-SEP-94 13:33:05 500 PROCESS 15.01 1.07 2.6 3 1.006 02 102 00 2.97 0.40 59 19 117 97 0.42 15.2 11.4 79 0.417 1.126 1.120 1.121 1.100 0.129 0.100 0.120 0.100 0.000
27-SEP-94 13:34:05 500 PROCESS 14.93 1.06 2.6 3 1.007 02 102 00 2.92 0.39 59 19 117 97 0.41 17.4 11.3 79 0.417 1.132 1.125 1.125 1.103 0.136 0.100 0.117 0.100 0.000
27-SEP-94 13:35:05 500 PROCESS 15.02 1.07 2.6 2 1.002 04 102 00 2.94 0.36 59 17 116 97 0.416 1.121 1.122 1.114 1.100 0.104 0.102 0.115 0.100 0.000
27-SEP-94 13:36:05 500 PROCESS 14.99 1.07 2.7 3 1.006 05 102 01 2.96 0.35 59 18 115 97 0.43 12.6 11.0 79 0.418 1.110 1.125 1.116 1.104 0.134 0.109 0.121 0.100 0.000
27-SEP-94 13:37:05 500 PROCESS 15.02 1.07 2.7 3 1.005 05 102 00 2.90 0.33 59 16 115 97 0.40 11.3 12.3 79 0.420 1.122 1.121 1.127 1.133 0.102 0.100 0.127 0.100 0.000
27-SEP-94 13:38:05 500 PROCESS 14.96 1.07 2.7 4 1.009 03 102 00 2.94 0.30 59 18 120 97 0.42 13.0 12.7 79 0.415 1.125 1.124 1.129 1.134 0.104 0.105 0.132 0.100 0.000
27-SEP-94 13:39:05 500 PROCESS 15.01 1.07 2.7 3 1.006 02 102 00 2.90 0.36 59 19 117 97 0.41 15.1 11.3 79 0.419 1.126 1.125 1.129 1.107 0.131 0.107 0.122 0.100 0.000
27-SEP-94 13:40:05 500 PROCESS 14.95 1.06 2.7 2 1.004 04 102 00 2.92 0.43 59 17 115 97 0.42 12.5 11.4 79 0.417 1.125 1.125 1.127 1.109 0.129 0.100 0.120 0.100 0.000
27-SEP-94 13:41:05 500 PROCESS 14.96 1.07 2.8 3 1.007 04 102 01 2.93 0.29 59 16 115 97 0.43 12.5 11.3 79 0.418 1.122 1.111 1.117 1.103 0.103 0.107 0.121 0.100 0.000
27-SEP-94 13:42:05 500 PROCESS 15.01 1.07 2.8 4 1.009 04 102 01 2.94 0.30 59 17 110 96 0.415 1.129 1.127 1.123 1.103 0.106 0.105 0.117 0.100 0.000
27-SEP-94 13:43:05 500 PROCESS 14.96 1.07 2.8 4 1.009 04 102 00 2.91 0.35 59 19 110 97 0.42 15.1 11.0 79 0.417 1.127 1.122 1.116 1.109 0.130 0.100 0.121 0.100 0.000
27-SEP-94 13:44:05 500 PROCESS 15.02 1.07 2.8 3 1.006 02 102 00 2.90 0.31 59 19 117 97 0.41 15.1 11.3 79 0.417 1.126 1.121 1.121 1.131 0.100 0.103 0.125 0.102 0.000
27-SEP-94 13:45:05 500 PROCESS 14.99 1.07 2.9 2 1.003 04 102 00 2.95 0.36 59 19 116 96 0.42 15.1 11.4 79 0.420 1.120 1.126 1.126 1.103 0.102 0.103 0.110 0.100 0.000
27-SEP-94 13:46:05 500 PROCESS 15.00 1.07 2.9 3 1.006 05 102 00 2.91 0.35 59 17 116 97 0.42 13.0 11.7 79 0.415 1.125 1.124 1.127 1.130 0.134 0.106 0.125 0.103 0.000
27-SEP-94 13:47:05 500 PROCESS 14.99 1.07 2.9 3 1.009 05 102 02 3.01 0.39 59 16 115 97 0.39 12.5 11.4 79 0.424 1.121 1.114 1.114 1.133 0.129 0.106 0.117 0.103 0.000
27-SEP-94 13:48:05 500 PROCESS 15.03 1.00 2.9 3 1.009 04 102 01 2.90 0.37 59 17 116 96 0.405 1.123 1.117 1.109 1.140 0.136 0.100 0.131 0.100 0.000
27-SEP-94 13:49:05 500 PROCESS 14.96 1.07 2.9 4 1.009 04 102 01 2.90 0.24 59 17 110 97 0.41 14.9 11.3 79 0.419 1.121 1.122 1.121 1.100 0.127 0.106 0.132 0.105 0.000
27-SEP-94 13:50:05 500 PROCESS 14.97 1.07 2.9 4 1.007 04 102 00 2.91 0.32 59 17 119 97 0.41 15.1 11.7 79 0.419 1.123 1.123 1.123 1.100 0.130 0.107 0.127 0.100 0.000
27-SEP-94 13:51:05 500 PROCESS 14.90 1.07 2.9 3 1.004 02 102 00 2.97 0.31 59 18 116 97 0.41 15.2 11.4 79 0.417 1.127 1.127 1.126 1.134 0.100 0.103 0.127 0.100 0.000
27-SEP-94 13:52:05 500 PROCESS 15.01 1.07 2.9 2 1.004 02 102 00 2.97 0.35 59 18 116 97 0.41 15.1 11.4 79 0.419 1.123 1.126 1.110 1.149 0.130 0.099 0.132 0.100 0.000
27-SEP-94 13:53:05 500 PROCESS 15.01 1.07 2.9 2 1.003 04 102 01 3.05 0.20 59 17 115 96 0.42 12.5 11.4 79 0.423 1.127 1.127 1.127 1.100 0.130 0.100 0.125 0.100 0.000
27-SEP-94 13:54:05 500 PROCESS 14.99 1.07 2.9 3 1.004 02 102 00 2.97 0.35 59 18 116 97 0.41 15.1 11.4 79 0.419 1.123 1.126 1.110 1.149 0.130 0.099 0.132 0.100 0.000
27-SEP-94 13:55:05 500 PROCESS 15.01 1.07 2.9 2 1.003 04 102 01 3.05 0.20 59 17 115 96 0.42 12.5 11.4 79 0.423 1.127 1.127 1.127 1.100 0.130 0.100 0.125 0.100 0.000
27-SEP-94 13:56:05 500 PROCESS 14.99 1.07 2.9 3 1.004 02 102 00 2.97 0.35 59 18 116 97 0.41 15.1 11.4 79 0.419 1.123 1.126 1.110 1.149 0.130 0.099 0.132 0.100 0.000

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BETWEEN PRODUCTION DATES: 10-09-10/HAY		HYDROGEN PRODUCTION DATES: 1-07-10/HAY	
EXTRACTING TIME:	20-2 WOUNDS	LAST 600 LEVEL:	3
CV76-1 - 2 3 EL	029760-1 0.012 A	017066-1	1.004 A
CV76-2 - 0 3 EL	029760-2 0.010 A	017066-2	1.002 A
CV76-3 - 0 3 EL	029760-3 0.008 A	017066-3	1.002 A
CV76-4 - 0 3 EL	029760-4 0.006 A	017066-4	1.002 A
CV76-5 - 0 3 EL	029760-5 0.004 A	017066-5	1.002 A
CV76-6 - 0 3 EL	029760-6 0.002 A	017066-6	1.002 A
CV76-7 - 0 3 EL	029760-7 0.000 A	017066-7	1.002 A
CV76-8 - 0 3 EL	029760-8 0.000 A	017066-8	1.002 A
CV76-9 - 0 3 EL	029760-9 0.000 A	017066-9	1.002 A
CV76-10 - 0 3 EL	029760-10 0.000 A	017066-10	1.002 A
CV76-11 - 0 3 EL	029760-11 0.000 A	017066-11	1.002 A
CV76-12 - 0 3 EL	029760-12 0.000 A	017066-12	1.002 A
CV76-13 - 0 3 EL	029760-13 0.000 A	017066-13	1.002 A
CV76-14 - 0 3 EL	029760-14 0.000 A	017066-14	1.002 A
CV76-15 - 0 3 EL	029760-15 0.000 A	017066-15	1.002 A
CV76-16 - 0 3 EL	029760-16 0.000 A	017066-16	1.002 A
CV76-17 - 0 3 EL	029760-17 0.000 A	017066-17	1.002 A
CV76-18 - 0 3 EL	029760-18 0.000 A	017066-18	1.002 A
CV76-19 - 0 3 EL	029760-19 0.000 A	017066-19	1.002 A
CV76-20 - 0 3 EL	029760-20 0.000 A	017066-20	1.002 A
CV76-21 - 0 3 EL	029760-21 0.000 A	017066-21	1.002 A
CV76-22 - 0 3 EL	029760-22 0.000 A	017066-22	1.002 A
CV76-23 - 0 3 EL	029760-23 0.000 A	017066-23	1.002 A
CV76-24 - 0 3 EL	029760-24 0.000 A	017066-24	1.002 A
CV76-25 - 0 3 EL	029760-25 0.000 A	017066-25	1.002 A
CV76-26 - 0 3 EL	029760-26 0.000 A	017066-26	1.002 A
CV76-27 - 0 3 EL	029760-27 0.000 A	017066-27	1.002 A
CV76-28 - 0 3 EL	029760-28 0.000 A	017066-28	1.002 A
CV76-29 - 0 3 EL	029760-29 0.000 A	017066-29	1.002 A
CV76-30 - 0 3 EL	029760-30 0.000 A	017066-30	1.002 A
CV76-31 - 0 3 EL	029760-31 0.000 A	017066-31	1.002 A
CV76-32 - 0 3 EL	029760-32 0.000 A	017066-32	1.002 A
CV76-33 - 0 3 EL	029760-33 0.000 A	017066-33	1.002 A
CV76-34 - 0 3 EL	029760-34 0.000 A	017066-34	1.002 A
CV76-35 - 0 3 EL	029760-35 0.000 A	017066-35	1.002 A
CV76-36 - 0 3 EL	029760-36 0.000 A	017066-36	1.002 A
CV76-37 - 0 3 EL	029760-37 0.000 A	017066-37	1.002 A
CV76-38 - 0 3 EL	029760-38 0.000 A	017066-38	1.002 A
CV76-39 - 0 3 EL	029760-39 0.000 A	017066-39	1.002 A
CV76-40 - 0 3 EL	029760-40 0.000 A	017066-40	1.002 A
CV76-41 - 0 3 EL	029760-41 0.000 A	017066-41	1.002 A
CV76-42 - 0 3 EL	029760-42 0.000 A	017066-42	1.002 A
CV76-43 - 0 3 EL	029760-43 0.000 A	017066-43	1.002 A
CV76-44 - 0 3 EL	029760-44 0.000 A	017066-44	1.002 A
CV76-45 - 0 3 EL	029760-45 0.000 A	017066-45	1.002 A
CV76-46 - 0 3 EL	029760-46 0.000 A	017066-46	1.002 A
CV76-47 - 0 3 EL	029760-47 0.000 A	017066-47	1.002 A
CV76-48 - 0 3 EL	029760-48 0.000 A	017066-48	1.002 A
CV76-49 - 0 3 EL	029760-49 0.000 A	017066-49	1.002 A
CV76-50 - 0 3 EL	029760-50 0.000 A	017066-50	1.002 A
CV76-51 - 0 3 EL	029760-51 0.000 A	017066-51	1.002 A
CV76-52 - 0 3 EL	029760-52 0.000 A	017066-52	1.002 A
CV76-53 - 0 3 EL	029760-53 0.000 A	017066-53	1.002 A
CV76-54 - 0 3 EL	029760-54 0.000 A	017066-54	1.002 A

APPENDIX B

MASTER TEST PLAN

FOR

ACCEPTANCE TESTING

OF THE

SPE® OXYGEN GENERATOR ASSEMBLY (OGA)

(REFURBISHMENT OF THE TECHNOLOGY DEMONSTRATOR
LFSPE OXYGEN GENERATION SUBSYSTEM)

CONTRACT NAS8-38250-23

BY

UNITED TECHNOLOGIES CORPORATION
HAMILTON STANDARD DIVISION
SPACE & SEA SYSTEMS
WINDSOR LOCKS, CT 06096

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Merlin A. Shuey
Program Manager

**MASTER TEST PLAN
REVISION SUMMARY**

REVISION	PAGE	DESCRIPTION	DATE
Basic	All	Initial release	4/10/95

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1.0 OBJECTIVE

The purpose of this Master Test Plan is to define a series of tests to be performed on the refurbished SPE Oxygen Generator Assembly (OGA). The SPE OGA has been refurbished to correct operational deficiencies identified during field testing of the unit, and to effect hardware and software changes to the system in order for it to be consistent with the most recent requirements for the International Space Station Alpha (ISSA). The test program defined in this document will verify the integrity of the subsystem hardware and software and will test the effectiveness of the refurbishment.

2.0 REFERENCE DOCUMENTS

The following documents for part of this document to the extent specified herein. If no documentation revision letter is shown, the latest revision will apply.

SVHSER16748	Software Requirements Specification for the SPE OGA Command & Display Unit
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SVHSER16750	Software Requirements Specification for the SPE OGA Process Controller
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3.0 TEST ARTICLE DESCRIPTION

The SPE OGA, shown schematically in Figure 2.0-1, safely generates oxygen and hydrogen gas from the electrolysis of water. The oxygen gas is generated and delivered at ambient pressure directly to the environment, while the hydrogen is generated at slightly elevated pressure for possible delivery to a CO₂ reduction system. The SPE OGA includes all valves, regulators, sensors and other controls for safe operation of the system.

The cell stack is a liquid anode feed water electrolyzer consisting of 18 SPE water electrolysis cells assembled in a bipolar arrangement between two compression end plates. In the electrolysis process, liquid water is fed to the

deionizer bed to ensure the water is free of any ionic contamination (cation and anion) that would be detrimental to cell life. A conductivity sensor located immediately downstream of the deionizer bed monitors water quality and performance of the deionizer bed. Water flow to the module is monitored by a flow switch located immediately upstream of the cell stack.

The oxygen gas produced in the SPE electrolyzer is free of hydrogen, with purities of 99.5% or greater typically measured. Since the SPE OGA has been designed to operate with hydrogen pressure always greater than oxygen pressure, redundant combustible gas sensors located at the oxygen outlet interface constantly monitor the oxygen for hydrogen. A pressure sensor initiates a shutdown should an obstruction occur in the delivery line, and a relief valve provides redundancy in the event of a failed pressure sensor.

The hydrogen-water exiting the cell stack is mostly hydrogen gas by volume with a small amount of liquid water present from protonic pumping in the ion exchange membrane. The hydrogen/water phase separator employs two cavities, each containing a hydrophilic and hydrophobic membrane, and is similar in design and operation to the polishing section of the oxygen/water phase separator. The hydrogen gas passes through the hydrophobic membranes to the hydrogen valve manifold containing the pressure control system, and the water is delivered to the "stripper" section of the phase separator. The stripper section contains four electrochemical hydrogen pumps that remove dissolved hydrogen from the water before it is returned to the water recirculation loop. The electrochemical hydrogen pump uses an SPE membrane and electrode assembly similar to the electrolysis membrane and electrode assembly. The degassed water is subsequently delivered to one of two metal bellows accumulators after dropping in pressure through a negative bias back pressure regulator referenced to hydrogen.

As stated previously, the water exiting from the separator is stored in one of two metal bellows accumulators. Two tanks, in conjunction with the four-way ball valve, are provided for fault isolation in the event of a failure of the hydrogen phase separator that is undetected by either the differential pressure sensor or the stripper cell voltage and current monitors. While

water is being fed to one tank from the phase separator the second tank is providing water, as required, to the water recirculation loop via the feed water pump. Employing two tanks in this manner ensures that hydrogen gas is not introduced into the system anode loop, where it would subsequently flow into the oxygen delivery system. As an additional back-up, redundant combustible gas sensors in the delivery system would detect hydrogen carry-over into the anode loop and initiate a system shutdown.

Hydrogen pressure control is maintained by a differential back pressure regulator referenced to nitrogen. The primary hydrogen regulator maintains hydrogen generation pressure 25 psid below nitrogen. Hydrogen pressure control is monitored by a pressure sensor; shutdown of the SPE OGA will occur if hydrogen pressure drifts above or below the normal band of the primary regulator. Mechanical backup for both low and high differential pressure is provided by the redundant differential back pressure regulator and relief valve, respectively. If the primary regulator fails closed and either the pressure sensor or controller fails to detect it, the redundant back pressure regulator will open to ensure nitrogen pressure is maintained above hydrogen. Conversely, should the primary regulator fail open and either the system instrumentation or controller fails to detect it, the nitrogen-hydrogen relief valve opens to introduce nitrogen into the hydrogen circuit to ensure hydrogen pressure is always maintained above oxygen pressure. A three-way solenoid valve at the regulator outlet directs flow to either the hydrogen outlet interface or to the vent interface.

As mentioned previously, nitrogen is used as a reference pressure for the hydrogen pressure control system. The nitrogen is also used as a purge gas during start-up and shutdown transient conditions: during start-up, the nitrogen purges any air from the hydrogen lines and, during shutdown, it purges hydrogen from the same lines. Nitrogen is introduced from the facility through a normally closed solenoid valve. A pressure sensor monitors the nitrogen pressure and controls the operation of the solenoid valve. A nitrogen accumulator provides sufficient purge volume to safely and effectively purge the hydrogen circuit during start-up and shutdown. Purging of the hydrogen circuit is accomplished by removing power to the

normally open solenoid valve located between the hydrogen and nitrogen circuit.

Feed water is provided to the SPE OGA from the facility through a normally closed solenoid valve. Operation of this valve is controlled by the water level in the two feed water metal bellows accumulators and the position of the four-way ball valve between the two tanks.

4.0 TEST EQUIPMENT

Testing of the refurbished SPE OGA will be conducted in one of four test cells in the Electrochemical Engineering Laboratory of Building 2 in Windsor Locks, CT. Required services for operating the system are:

- 115 VAC, 60 Hz, 3 phase, 20 amps (provided by Hamilton Standard Rig 216)

- 28 VDC, 15 amps

- IBM Personal System/2, Model 50Z (50-031), with the following minimum attributes:

Operating system:	DOS 3.0
Mass Storage:	Fixed disk and removable disk
Memory:	1 Mbyte RAM
Printer:	Epson FX-1050

- Test stand for fluid control: nitrogen inlet; feed water inlet; hydrogen outlet; oxygen outlet

- Recirculating chiller, 1 GPM water, 65°F, minimum 1000 watts heat rejection

Other test equipment as required to successfully complete the test objectives described herein will be described in the applicable section.

5.0 TEST PLAN

This section defines the tests to be performed on various subassemblies within the SPE OGA prior to final assembly and on the system itself once installation into the test facility is complete. At the conclusion of each phase of the test program the test conductor and a separate reviewer will verify, by signature, that the tests were conducted in accordance with the test plan and the results recorded in the test plan were actual measurements. Red-lining of this document in order to successfully complete the defined test objective is permissible. No other review of this test program is planned or anticipated.

5.1 Electrolysis Cell Stack Testing

Testing of the electrolysis cell stack is conducted prior to installation into the system to verify the mechanical and electrical integrity of the assembly and to measure individual cell performance at the SPE OGA operating conditions.

5.1.1 Cell stack electrical testing

Once assembly of the 18-cell SPE water electrolysis cell stack is completed, the module is tested to verify no electrical shorts are present. This is accomplished by utilizing the cell short check meter, which charges the cell with a battery to a potential of approximately 1 VDC. Once charged, the battery is removed and the cell potential is allowed to decay. If the decay rate is too sudden, an electrical short is present. The short must be repaired prior to initiating any further testing of the module.

- 1) Attach short check meter to cell #1.
- 2) Charge the cell to approximately 1 VDC. Remove power to the cell.
- 3) Observe the cell potential decay rate; if the rate is too sudden, the cell has an electrical short that must be corrected prior to continuing the test program.

- 4) Repeat steps 1-3 for the remaining cells in the assembly.

Conducted by: [Signature] Verified by: Phil J. Roy

5.1.2 Cell stack mechanical testing

After the electrical integrity of the 18-cell stack has been verified, the module is brought to proof pressure and is subjected to an overboard and cross-cell leakage test.

5.1.2.1 Overboard proof pressure and leakage test

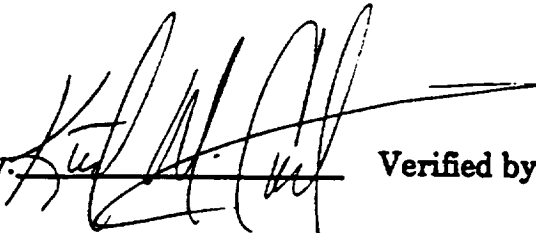
Proof pressure testing of the electrolysis module will be at a minimum pressure of 2 times the maximum allowable working pressure (MAWP). For the refurbished SPE OGA, the MAWP is 75 psig, resulting in a proof pressure test of 150 psig. Proof pressure testing of the module will be conducted with nitrogen, since the proof pressure limit is well within the normal operating capability of the cell hardware (approximately 400 psig). Once the proof pressure test of the module is completed, the nitrogen pressure is reduced to the MAWP and an overboard leakage test is conducted.

- 1) Attach a clean, regulated nitrogen supply to the water inlet manifold and the hydrogen-water outlet manifold. The nitrogen source should have a pressure gauge to monitor pressure at the electrolysis module, and a shut-off valve to isolate the nitrogen source from the test item.
- 2) Cap the oxygen-water and the remaining hydrogen-water outlet manifold.
- 3) Slowly pressurize the cell stack by increasing the regulator setting in 10 psig increments.

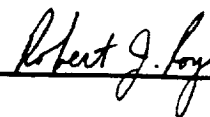
4) Continue to increase pressure until the nitrogen pressure on the gauge equals $150 +2/-0$ psig. Maintain this pressure for a minimum of 5 minutes. After the 5 minute period, slowly depressurize the module by decreasing the regulator setting to 1.0 times the MAWP, or 75 psig.

5) Close the shut-off valve to isolate the module from the nitrogen source. Carefully monitor the nitrogen pressure in the module. No decay is allowed in a 30 minute test period.

Conducted by:



Verified by:



5.1.2.2 Cross-cell leakage test

Upon successful conclusion of the module leakage test, the nitrogen lines to the cell stack are reconfigured such that only the hydrogen side of the cells is pressurized. The oxygen side of the cell stack is left open to ambient pressure, while the hydrogen side is pressurized with nitrogen to three different pressure levels. The gas flow rate across the 18 cells is measured, and it must be below the normal permeation rate for nitrogen across Nafion membrane at each of the pressure levels. If a higher rate is detected, a leak is present across one or more of the electrolysis cells, either across the cell membrane itself or into one of the fluid headers. A cross-cell leak must be repaired prior to initiating any further testing of the module.

- 1) Attach a clean, regulated nitrogen supply to either of the two hydrogen-water outlet manifold ports. Cap the remaining port.
- 2) Attach a plastic line to either the water inlet manifold port or the oxygen-water outlet manifold port. Cap the remaining port.
- 3) Insert the other end of the plastic line in a beaker filled with DI water. Install an inverted burette in the beaker and fill the burette with

water by using a pipette bulb. Place the plastic line in the open end of the burette.

- 4) Pressurize the hydrogen side of the cell stack with nitrogen to the pressure levels indicated below; determine the gas flow rate by measuring the volume of water displaced by the nitrogen in the burette. The permeation rate should not exceed the values listed below.

N₂ pressure (psig)	Maximum permeation rate (cc/min/18-cells @ 72°F)	Measured permeation rate (cc/min/18-cells @ 72°F)
50	2.6	<u>2.6</u>
75	4.0	<u>4.0</u>
100	5.3	<u>5.2</u>

- 5) Slowly depressurize the module and disconnect the nitrogen lines from the module. Refill the manifolds with fresh, DI water, and cap all the fluid ports on the module.

Conducted by: [Signature] Verified by: Robert J. Roy

5.1.3 Cell stack operational test

A 100 hour operational test of the 18-cell electrolysis stack is conducted to verify the performance of each of the cells within the assembly. The test is conducted in a separate test rig at the SPE OGA maximum operating current density. Individual cell potentials should fall within the range of approximately 1.70-1.75 Vdc at a current density of 215 amps/ft². Water flow rate, operating temperature, and cell current will also be monitored during the conduct of this test.

- 1) Install the 18-cell module in the mobile test rig. Connect the hydrogen-water outlet manifold to a phase separator, with the hydrogen

delivery to the laboratory vent and the water delivery to the laboratory drain.

- 2) Verify the test rig data acquisition program is operational.
- 3) Turn the recirculation pump on; verify a minimum flow rate of 100 cc/min/cell, or 1800 cc/min through the electrolysis module.
- 4) Turn the electrolysis power supply on and set the current level for approximately 5 amps. Monitor individual cell voltages, ensuring proper charging of each of the 18-cells.
- 5) Increase the current setting to 50 amps; note the time on the test rig timer. Operate the module for 100 hours. Set the data acquisition system to record performance data of the module at the rate of once per hour.
- 6) At the conclusion of the test program, verify performance of the cells is within acceptable limits. Remove the module from the test rig and fill the manifold ports with fresh, DI water. Cap all the manifold ports.

Conducted by: Robert J. Fry Verified by: Lawrence C. Mott

5.2 Oxygen Phase Separator Testing

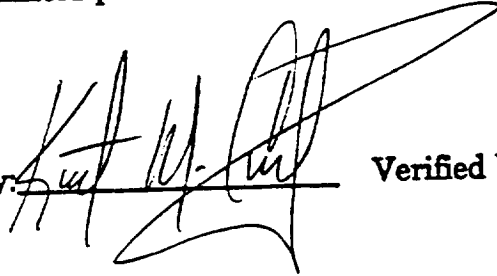
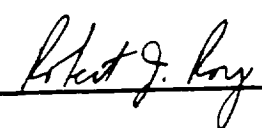
Testing of the oxygen phase separator is conducted prior to installation into the system to verify the mechanical integrity of the assembly and to verify the performance of the hydrophilic and hydrophobic membranes.

5.2.1 Mechanical testing

The oxygen phase separator assembly is subjected to a proof pressure test at a minimum pressure of 2 times MAWP for the recirculating water loop, followed by a leakage test at a minimum pressure of 1 times MAWP. For the

refurbished SPE OGA, the MAWP of the recirculating water loop is 30 psig, resulting in a proof pressure test requirement of 60 psig. When conducting proof pressure and leakage testing, all three fluid ports (two phase inlet, water outlet and oxygen outlet) are simultaneously pressurized to protect the separator membranes from high differential pressures. Once the proof pressure test of the separator is completed, the nitrogen pressure is reduced to the MAWP and a leakage test is conducted.

- 1) Attach a clean, regulated nitrogen supply to the oxygen-water inlet manifold, the oxygen outlet manifold and the water outlet manifold. The nitrogen source should have a pressure gauge to monitor pressure at the electrolysis module, and a shut-off valve to isolate the nitrogen source from the test item.
- 2) Slowly pressurize the separator assembly by increasing the regulator setting in 10 psig increments.
- 3) Continue to increase pressure until the nitrogen pressure on the gauge equals $60 +2/-0$ psig. Maintain this pressure for a minimum of 5 minutes. After the 5 minute period, slowly depressurize the separator by decreasing the regulator setting to 1.0 times the MAWP, or 30 psig.
- 5) Close the shut-off valve to isolate the separator from the nitrogen source. Carefully monitor the nitrogen pressure in the separator. No decay is allowed in a 30 minute test period.
- 6) At the conclusion of the leakage test, remove the nitrogen lines and fill the manifold ports with fresh DI water.

Conducted by:  Verified by: 

5.2.2 Performance testing

Performance testing of the separator is conducted prior to installation of the separator assembly into the system package to verify proper operation of the hydrophilic and hydrophobic membranes. Testing of the oxygen phase separator is conducted in the phase separator development test rig in the Electrochemical Engineering Laboratory in Building 2. The separator is to be tested with only water flowing through the assembly (no oxygen generation), and with a two phase mixture generated from a 12-cell electrolysis stack operating at 150% of the maximum current density level for the OGA 18-cell stack. Membrane pressure drop and water flow rate will be monitored. No water carry-over into the product gas stream is allowed. The amount of gas present in the water outlet stream will be measured; the level of gas present should not exceed that predicted by Henry's Law.

- 1) Install the oxygen phase separator assembly in the phase separator development test rig.
- 2) Start the test rig. Verify a water flow rate of 1800 cc/min through the 12-cell electrolysis stack.
- 3) Record the hydrophilic and hydrophobic membrane pressure drop. Verify outlet streams are clean, i.e. no gas in the water outlet and no water in the gas outlet.
- 4) Turn the electrolysis power supply on and set the current level to approximately 3 amps. Record the hydrophilic and hydrophobic membrane pressure drop.
- 5) Slowly increase the current level to the cell stack to 75 amps. Record the hydrophilic and hydrophobic membrane pressure drop. Verify the outlet streams are clean (NOTE: Occasional bubbles in the water outlet stream are expected due to gas evolving from solution due to the drop in pressure across the hydrophilic membranes).

6) Measure the amount of gas being evolved in the water loop due to the drop in pressure by installing a graduated cylinder immediately downstream of the separator water exit. The oxygen evolution rate should not exceed 21 cc/min.

Measured evolution rate: 7 cc/min

7) Cycle the current setting to the electrolysis cell stack; verify proper operation of the phase separator at both extremes of operating current levels.

8) At the conclusion of the test fill the manifold ports with fresh DI water.

Conducted by: Robert J. Fry Verified by: L.P. Moulden

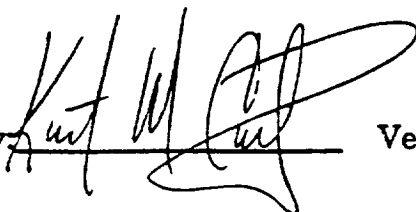
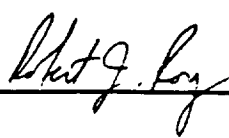
5.3 Hydrogen Phase Separator Testing

Testing of the hydrogen phase separator is conducted prior to installation into the system to verify the mechanical and electrical integrity of the assembly and to verify the performance of the hydrophilic and hydrophobic membranes.

5.3.1 Electrical testing

Once the hydrogen phase separator is assembled, the electrochemical hydrogen pumps in the stripper section of the separator are tested to verify no electrical shorts are present. This is accomplished by utilizing the cell short check meter in the same manner as it was used to test the electrolysis cells. Each of the four cells is individually charged and, once charged, the cell potential is allowed to decay. If the decay rate is too sudden, an electrical short is present that must be rectified prior to operation of the assembly.

- 1) Attach short check meter to pump #1.
- 2) Charge the cell to approximately 1.0 VDC. Remove power to the cell.
- 3) Observe the cell potential decay rate; if the rate is too sudden, the cell has an electrical short that must be corrected prior to continuing the test program.
- 4) Repeat steps 1-3 for the remaining cells in the assembly.

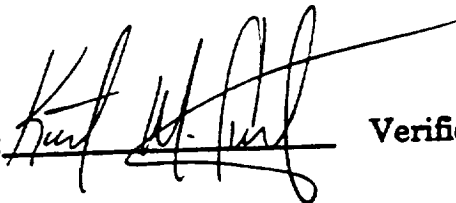
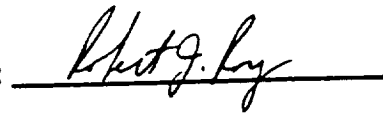
Conducted by  Verified by: 

5.3.2 Mechanical testing

The hydrogen phase separator assembly is subjected to a proof pressure at a minimum pressure of 2 times MAWP for the hydrogen-water circuit, followed by a leakage test at a minimum pressure of 1 times MAWP. For the refurbished SPE OGA, the MAWP of the hydrogen-water circuit is 75 psig, resulting in a proof pressure test requirement of 150 psig. When conducting proof pressure and leakage testing, all three fluid ports (two phase inlet, water outlet and hydrogen outlet) are simultaneously pressurized to protect the separator membranes and the electrochemical hydrogen pump membrane and electrode assemblies from high differential pressures. Once the proof pressure test of the separator is completed, the nitrogen pressure is reduced to the MAWP and a leakage test is conducted.

- 1) Attach a clean, regulated nitrogen supply to the hydrogen-water inlet manifold, the hydrogen outlet manifold and the water outlet manifold. The nitrogen source should have a pressure gauge to monitor pressure at the electrolysis module, and a shut-off valve to isolate the nitrogen source from the test item.

- 2) Slowly pressurize the separator assembly by increasing the regulator setting in 10 psig increments.
- 3) Continue to increase pressure until the nitrogen pressure on the gauge equals $150 \pm 2/-0$ psig. Maintain this pressure for a minimum of 5 minutes. After the 5 minute period, slowly depressurize the separator by decreasing the regulator setting to 1.0 times the MAWP, or 75 psig.
- 5) Close the shut-off valve to isolate the separator from the nitrogen source. Carefully monitor the nitrogen pressure in the separator. No decay is allowed in a 30 minute test period.
- 6) At the conclusion of the leakage test, remove the nitrogen lines and fill the manifold ports with fresh DI water.

Conducted by:  Verified by: 

5.3.3 Performance testing

Performance testing of the separator is conducted prior to installation into the system package to verify proper operation of the hydrophilic and hydrophobic membranes during transient and steady state conditions. Testing of the hydrogen phase separator is conducted in the phase separator development test rig in the Electrochemical Engineering Laboratory in Building 2. Since the test rig has no provisions to evaluate the performance of the electrochemical hydrogen pumps, only the performance of the hydrophilic and hydrophobic membranes will be verified. The separator is to be tested at ambient pressure and at the system maximum expected operating pressure of 75 psia (assumes nitrogen reference pressure of 100 psia), and at cell current levels ranging from the standby level of 2 amps to the maximum current level of 50 amps (for the 18-cell SPE OGA stack; since the test rig contains only a 12-cell stack, the cell current levels will be 50% higher, or 3 amps for standby and 75 amps for the maximum current

level). Membrane pressure drop at all operating conditions will be monitored to ensure the bubble point of the hydrophilic membrane is not exceeded. No water carry-over into the product gas stream is allowed. The amount of gas present in the water outlet stream will be measured; the level of gas present should not exceed that predicted by Henry's Law.

- 1) Install the hydrogen phase separator assembly in the phase separator development test rig.
- 2) Start the test rig. Verify a water flow rate of 1800 cc/min through the 12-cell electrolysis stack.
- 3) Turn the electrolysis power supply on and set the current level to approximately 3 amps. Record the hydrophilic and hydrophobic membrane pressure drop.
- 5) Slowly increase the current level to the cell stack to 75 amps. Record the hydrophilic and hydrophobic membrane pressure drop. Verify the outlet streams are clean (NOTE: Occasional bubbles in the water outlet stream are expected due to gas evolving from solution due to the drop in pressure across the hydrophilic membranes).
- 6) Slowly increase the hydrogen back pressure to approximately 75 psia, ensuring the differential back pressure regulator controlling the two-phase inlet pressure accurately tracks the increasing hydrogen pressure. Record the hydrophilic and hydrophobic membrane pressure drop. Verify the outlet streams are clean.
- 7) Decrease the current setting to the electrolysis cell stack to 3 amps, the standby current level. Record the hydrophilic and hydrophobic membrane pressure drop.
- 8) Return the current level to the electrolysis stack to 75 amps. Measure the amount of gas being evolved in the water due to the drop in pressure by inserting the outlet water stream in the opening of an

inverted burette. The hydrogen evolution rate should not exceed 3.1 cc/min when the pressure is dropped from 75 psia to ambient.

Measured evolution rate: 2.7 cc/min

9) Continue to cycle the current setting to the electrolysis cell stack; verify proper operation of the phase separator at both extremes of operating current levels.

10) At the conclusion of the test fill the manifold ports with fresh DI water.

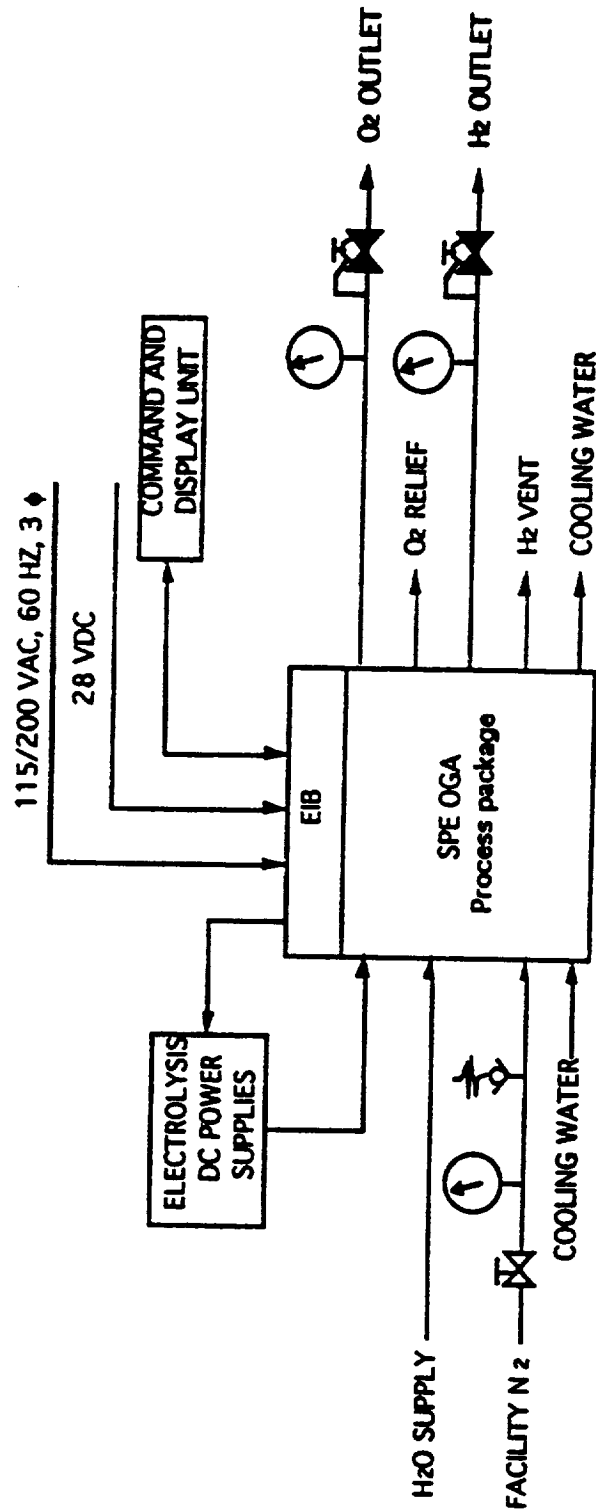
Conducted by: Robert J. Long Verified by: L. C. Moody

5.4 System Check-out Testing

A system check-out test will be performed on the complete SPE OGA prior to the generation of oxygen and hydrogen gas. The test program will include validation of the system installation into the test facility, verification of system communication between the Electrical Interface Box (EIB) and the Command & Display Unit (CDU), proof pressure testing of the system at 2 times MAWP, and leakage testing at 1 times MAWP. Upon successful completion of the system check-out test program, performance testing of the system can be initiated.

5.4.1 Verify installation

Prior to operation of the unit, proper installation into the test facility must be verified. A schematic of the test set-up is included as Figure 5.4.1-1. Both the oxygen and hydrogen outlet lines from the OGA will be connected to their respective interfaces on the fluids control panel. The oxygen relief interface will be allowed to vent to ambient, while the hydrogen vent interface will be connected to a line vented outside of the test cell. Feed water will be supplied



**FIGURE 5.4.1-1
SPE OGA TEST SCHEMATIC**

by the facility DI water system; regulated nitrogen will be supplied by the facility nitrogen farm. Electrical power will be supplied by Rig 216 for the 115 VAC, 60 Hz, 3 phase power, and by a Kepco power supply for the 28 Vdc requirement. All electrical connections between the electrolysis DC power supply cart and the system will be completed. Chilled water for the OGA liquid-liquid heat exchanger will be supplied by a recirculating chiller at a flow rate of 1 GPM and a temperature of 65°F. The chiller will have a minimum heat rejection capacity of 1000 watts, minimum.

Once installation into the facility is completed, the CDU software will be loaded into an IBM personal computer which will serve as the CDU. A harness linking the EIB to the CDU will be installed, and a line printer to record system performance data will be connected to the computer.

Conducted by: *R. G. Roy* Verified by: *J. C. [Signature]*

5.4.2 Electrical Component Check-out Testing

Electrical testing of the system is conducted prior to conducting any other acceptance test to verify proper communication between the system controller in the EIB and the CDU, proper actuation of all electrical components within the system package and to verify proper installation of the wiring harnesses.

5.4.2.1 Controller/Display Check-out

Check-out testing of the CDU display is conducted to verify proper status of all actuated components and proper output of all instrumentation with the system in the OFF mode OFF state.

- 1) Verify the RS-232 communications cable is properly installed between the CDU and the system EIB.

- 2) Apply power to the EIB and the CDU. Verify the system is in the OFF mode OFF state.
- 3) Compare the status of all actuated components with the required status in the Effector Control State Definition Table of the SPE OGA Process Controller Software Requirements Specification (SRS) for the POR state. There shall be no discrepancies.
- 4) Compare the values of all system parameters on the system parameter screen with the values listed in Table 5.4.2.1-I. All values shall be within the ranges specified.
- 5) Select the Assembly Configuration screen on the CDU by depressing the F4 key on the keyboard. The Oxygen Delivery configuration shall be set to "CONTINUOUS", and the Hydrogen Delivery configuration shall be set to "VENT".

Conducted by: *W. J. Long* Verified by: *R. C. Morley*

5.4.2.2 Component Actuation/Harness Check-out

All electrical components (with the exception of the electrolysis power supply and electrochemical hydrogen pump power supply) are actuated to verify proper sequence by the controller in the EIB and to verify the integrity of the electrical harnesses. Actuation of some of the components in the system is governed by control laws contained in the Effector Control Function section of the SRS. As a result, the controller may override and/or ignore the user's commands.

- 1) Verify that the system and the CDU power is on and that the system is in the OFF mode OFF state.

**TABLE 5.4.2.1-I
SPE OGA OPERATING PARAMETERS**

<u>SENSOR</u>	<u>DESCRIPTION</u>	<u>VALUE</u>
W745	Recirculating water loop flow switch	NO FLOW
LEV606	Recirc. water loop bellows accum. level	0-55 in ³
LEV605-1	Feed water bellows accumulator level	0-55 in ³
LEV605-2	Feed water bellows accumulator level	0-55 in ³
CVOLUME	Calculated proton water volume	0-30 in ³
MVOLUME	Measured proton water volume	0-30 in ³
P7061	Oxygen outlet pressure sensor	15 ± 1 psia
P7062	Nitrogen reference pressure sensor	15 ± 2 psia
P7063	Oxygen generation pressure sensor	1 ± 1 psig
DP709	Oxygen phase separator differential	1 ± 1 psid
DP708	Hydrogen phase separator differential	1 ± 1 psid
P749	Hydrogen pressure sensor	1 ± 1 psig
T762-1	Recirc. water loop temperature	Amb. ± 2°F
T762-2	Recirc. water loop temperature	Amb. ± 2°F
T736-1	Heat exchanger water outlet temp.	Amb. ± 2°F
T736-2	Heat exchanger water outlet temp.	Amb. ± 2°F
CG746-1, 2	Combustible gas sensor, ambient	1 ± 1% LEL
CG746-3, 4	Combustible gas sensor, oxygen outlet	1 ± 1% LEL
CS755	Recirc. water loop conductivity sensor	<10umho/cm
I766	Electrolysis cell stack current sensor	1 ± 1 amps
H2V768-1	Electrochemical hydrogen pump cell	< 1 VDC
thru -4	potential	
I768-1 thru	Electrochemical hydrogen pump cell	.005 ± .005 A
-4	current	
VLT906-1	Electrolysis cell potential	< 1 VDC
thru -18		

- 2) Place the system in the MANUAL mode by depressing the F3 key on the keyboard, followed by selecting the MANUAL mode. Once in the MANUAL mode, depressing the F5 key on the keyboard, followed by entering the correct password, brings up the MANUAL mode menu screen.
- 3) Actuate, in order and singularly, the components listed in the table. Measure the power requirement of each actuated component and record in Appendix A. Deactivate each component upon verification of its proper operation. Record and resolve any problems encountered during actuation of any component.
- 4) Return to the Mode Selection screen and place the system in the OFF mode. Verify the system transitions to the OFF mode OFF state.

Conducted by: *Robert J. Long* Verified by: *J. C. Murphy*

5.4.2.3 Controller Setpoints

The controller in the EIB uses variable setpoints in the control software to allow flexibility during testing of the SPE OGA. Prior to initiating acceptance testing of the system, the correct values for the setpoints are verified.

- 1) Verify that the system and the CDU power is on and that the system is in the OFF mode OFF state.
- 2) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard.
- 3) Verify the Oxygen Requirement is set at 7.40 lb/day, the Light Side is set at 54 minutes and the Dark Side is set at 36 minutes, the respective default settings.

- 4) View the setpoint data by depressing the F1 key on the keyboard. Verify the values for the setpoints by comparing to the CDU Setpoint Communication Data Packet Tables contained in the Control & Display Unit Communication Inputs section of the Process Controller SRS. Resolve any discrepancies between the values in the table and those displayed on the screen before proceeding further.

Conducted by: Robert J. Loy Verified by: L. P. Morley

5.4.2.4 Verification of System Anomalies

The SPE OGA has been designed to safely generate oxygen and hydrogen gas from the electrolysis of water. System instrumentation, in conjunction with the system controller, constantly monitor system health and performance. If the controller monitors an out-of-limit condition, an automatic shutdown of the system is initiated. Prior to conducting performance testing of the system, all system shutdown levels will be verified. Refer to the Fault Detection Function section of the Process Controller SRS for a listing of all anomalies and the associated shutdown level, and the Anomaly Messages section of the CDU SRS for the corresponding error messages. The procedures for safely conducting the verification of the shutdown levels will be developed at the time of testing. In most instances, the sensor will be replaced with an alternate stimulus that would replicate the signal the controller would expect to receive from that sensor. The stimulus would then be varied until the anomaly was triggered. The system will remain in the OFF mode for the duration of this phase of testing. As each anomaly is verified, confirm the system transitions from the OFF mode OFF state to the OFF mode FAILURE state. The anomaly can be cleared by changing modes for a Level 2 anomaly (transition from the OFF mode to the IMMEDIATE SHUTDOWN mode and back again), or by cycling power to the EIB to reset the controller for a Level 1 anomaly.

Conducted by: Robert J. Loy Verified by: L. P. Morley
(SEE DATA SHEETS AT END OF
TEST PLAN)

5.4.3 Proof pressure test

A proof pressure test of 2 times the MAWP of the fluid circuit with the highest pressure will be conducted on the complete SPE OGA system (for the SPE OGA, the nitrogen reference is the highest). Since the three metal bellows water accumulators have been proof pressure tested previously as part of the Technology Demonstrator program, and they will have already been charged with nitrogen, they will not be subjected to an additional proof pressure test in order to prevent damage to the bellows itself. In addition, the Item 7063 pressure sensor will be removed to prevent damage to the sensor diaphragm, and the Item 163 relief valve outlet will be capped to prevent loss of nitrogen during the test. The isolation valve to the combustible gas sensor housing located at the oxygen outlet of the oxygen phase separator assembly will also be closed to prevent damage to the sensors.

Since the system has been designed to prevent reverse fluid flows and the inadvertent pressurization of one fluid loop with fluid from another, proof pressure and leakage testing of the system must be conducted by introducing the pressurizing fluid at different locations within the system. Pressurizing upstream and downstream of some components (in particular, the membranes of the phase separator which allow one fluid to pass but not the other) ensures they will not be damaged internally during the proof pressure test. Sufficient safeguards exist in the system, however, to prevent damage due to pressure excursions during normal system operation.

- 1) Verify the outlet to the Item 163, nitrogen relief valve, is capped.
- 2) Verify Items 080-1 and 080-2, the shut-off valves to the Item 605-1 and Item 605-2, feed water bellows accumulators, are closed.
- 3) Verify Items 080A-1 and 080A-2, the shut-off valves to the Item 606, recirculating water loop bellows accumulator, are closed.
- 4) Verify Item 080-3, the shut-off valve for the oxygen phase separator, is closed.

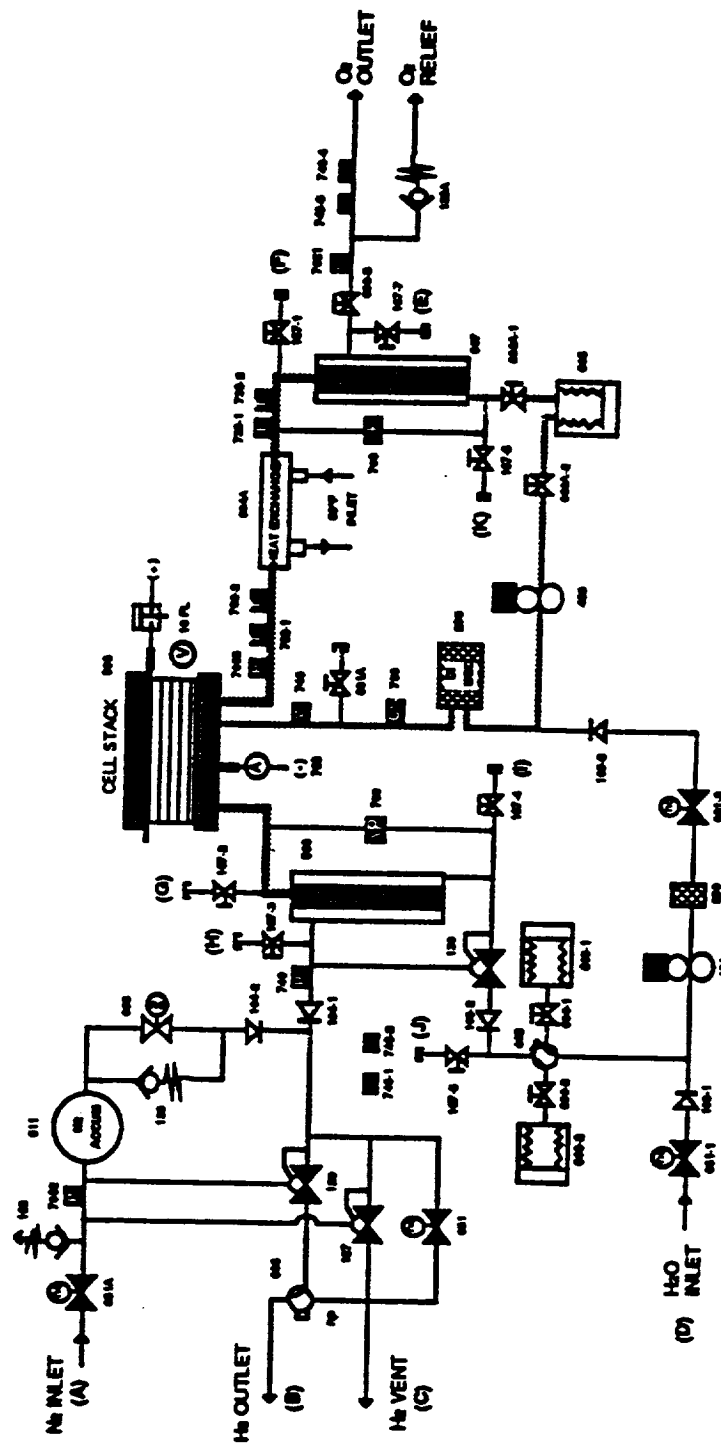
- 5) Item 051A, nitrogen pressurization solenoid valve, and Items 081-1 and 081-2, feed water solenoid valves, must be energized open in order to pressurize the nitrogen and feed water circuits. Disconnect the electrical harness at connector designation J801, and install the proof pressure test cable to energize the valves from a separate 115 VAC, 60 Hz supply.
- 6) Attach a regulated nitrogen supply to the system using flexible lines at the following points in the system (refer to Figures 5.4.5-1 and 5.4.5-2):

- a) The nitrogen inlet interface of the system package.
- b) The hydrogen outlet interface of the system package.
- c) The hydrogen vent interface of the system package.
- d) The water inlet interface of the system package.
- e) The shut-off valve at the oxygen phase separator oxygen outlet (Item 167-7).
- f) The shut-off valve downstream of the temperature sensor block housing Items 736-1 and 736-2 (Item 167-1).
- g) The shut-off valve upstream of the two-phase inlet to the hydrogen phase separator assembly (Item 167-2).
- h) The shut-off valve attached to the hydrogen valve manifold at the top of the system package (Item 167-3).
- i) The shut-off valve downstream of the water outlet of the hydrogen phase separator assembly (Item 167-4).
- j) The shut-off valve downstream of the Item 105-2 check valve (Item 167-5).
- k) The shut-off valve downstream of the oxygen phase separator water outlet (Item 167-6).

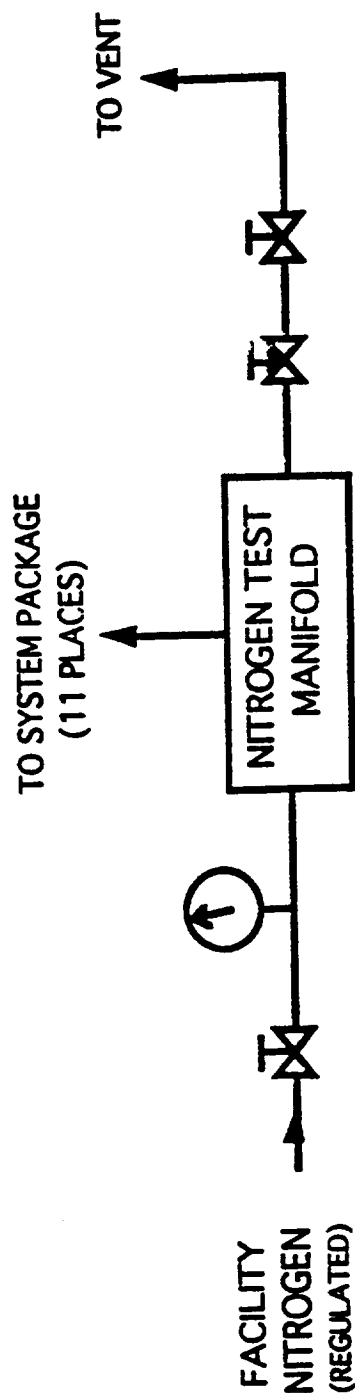
- 7) Disconnect the electrical harness and remove Item 7063, oxygen pressure sensor, from its port; cap the empty port. Reconnect the electrical harness to the sensor. *ALSO, REMOVE ITEM 749 FROM ITS PORT AND CAP THE EMPTY PORT. JON RL*

- 8) Verify the CDU is installed and the power is on. Turn the system power on and verify the system is in the OFF mode OFF state.

- 9) During pressurization of the system, monitor Items 708, 709 and ~~706~~ *deleted* (differential pressure sensors), Items 605-1, 605-2, and 606 (metal bellows accumulators), and Item 7061 (oxygen pressure sensor). The values *ΔP shown on RL*



**FIGURE 5.4.5-1
SPE OGA PROOF PRESSURE INTERFACE LOCATIONS**



**FIGURE 5.4.5-2
PROOF PRESSURE TEST SET-UP**

displayed on the CDU should only vary within acceptable electrical noise levels, and should not show any clear trends of increasing values with increasing pressurization. If any trend appears, immediately stop the test, depressurize the system and resolve the discrepancy.

10) Verify the nitrogen regulator is closed and that there is no pressure in the nitrogen test manifold by opening the needle valve in the manifold to exhaust any pressure. Close the needle valve.

11) Open the nitrogen supply valve upstream of the nitrogen test manifold.

12) Verify the shut-off valves from Step 6 (Items 167-1 thru 167-5) are completely open. Energize the Item 051A, nitrogen solenoid valve, and Items 081-1 and 081-2, water solenoid valves, using the separate harness installed in step 5. *7 p. 10*

13) Slowly pressurize the system by increasing the regulator setting in 10 psig increments. Allow the pressure readings on the nitrogen pressure gauges and the differential pressure sensors to stabilize prior to increasing pressure.

14) Continue to increase pressure until the nitrogen pressure on the gauge equals 150 +2/-0 psig. Maintain this pressure for a minimum of 5 minutes. After the 5 minute period, slowly depressurize the system by opening the needle valve in the nitrogen test manifold. Monitor the differential pressure sensors to ensure equal depressurization throughout the system. After depressurization, visually check for any permanent deformation. No deformation is allowed.

Conducted by: D.A. K. [Signature] Verified by: [Signature]

5.4.4 System leakage test

Leakage testing of the system can be conducted immediately after the proof pressure test by limiting the depressurization level to 1 times MAWP (75 psig). Otherwise, it is necessary to repeat Steps 1-13 as outlined in the proof pressure test procedure.

14) Continue to increase pressure until the nitrogen pressure on the gauge equals $75 +2/-0$ psig. Maintain this pressure for a minimum of 5 minutes. After the 5 minute period, close the nitrogen inlet valve and monitor the nitrogen pressure for 15 minutes. No decay in pressure is permissible. If the pressure decays, use leak detection fluid to determine the source of any gas leaks in the oxygen and hydrogen circuits, and search for water leaking in water containing circuits. As an option, the system may be depressurized and recharged with helium, and a helium detector employed to determine the source of any leak. Correct any leak before proceeding further in the test program.

15) At the conclusion of the test, slowly depressurize the system by opening the needle valve in the nitrogen test manifold. Monitor the differential pressure sensors to ensure equal depressurization throughout the system.

16) Restore the system to its original configuration before proceeding further in the test program.

Helium
SNIPP TEST
CONDUCTED
PRIOR TO
N₂ DECAT
TEST TO
ENSURE
LEAK TIGHT
HYDROGEN
SYSTEM.
RR
[Signature]

Conducted by: DA. Koo Verified by: [Signature]

5.5 Mode/State Transition Verification

The various mode and state transitions allowed for the SPE OGA will be demonstrated to verify proper sequencing of the software controller through the appropriate states within a mode and to verify correct control of system

hardware within a state (refer to the Effector Control Function section of the Process Controller SRS). A test schematic for conducting these tests is presented in Figure 5.4.1-1. The Oxygen Delivery configuration and Hydrogen Delivery configuration will remain at their default values of "CONTINUOUS" and "VENT", respectively, and the Oxygen Requirement will remain at its default setting of 7.40 lb/day for the purposes of this test sequence.

5.5.1 PURGE State

The following test procedures verify proper transition of the system from the OFF state to the PURGE state, and from the PURGE state to the PROCESS-VENT state, and demonstrate effector controls applicable to the PURGE state.

- 1) Turn the power to the system on. Verify the system is in the OFF mode OFF state.
- 2) Select the Mode Selection screen on the CDU by depressing the F3 key on the keyboard and select the ON mode. Verify the system transitions from the OFF mode OFF state to the ON mode PURGE state. Upon entering the PURGE state, the following effector controls are active (refer to the Effector Control State Definition Table in the Process Controller SRS):

- V081-1 Fill Control
- V051A & V053 Purge Control
- PS797 On Control

In addition, the recirculating water pump, Item 463, is energized and the flow is set for "RECIRC" gpm throughout all states in the ON mode. Verification of the correct operation of these controls is described below:

V081-1 Fill Control: The feed water inlet valve (Item 081-1) is set to "OPEN" if the feed water accumulator level (LEV605-2 if V003 is

"FILL1/DRAIN2" or LEV605-1 if V003 is "FILL2/DRAIN1") is less than the operating band low limit, "LOWLEV" in³. The valve is set to "SHUT" if the feed water accumulator level is greater than the maximum drain tank level, "MEDLEV" in³.

V051A & V053 Purge Control: The facility nitrogen inlet valve (Item 051A) is set to "SHUT" and the system nitrogen purge valve (Item 053) is set to "OPEN" upon entry into the PURGE state. After a period of water recirculation ("ACCTIME" minutes), the facility nitrogen inlet valve is set to "OPEN". The system nitrogen purge valve (Item 053) is set to "SHUT" once the nitrogen inlet valve (Item 051A) has been open for greater than the purge time ("N2PTIME" minutes).

PS797 On Control: The hydrogen phase separator electrochemical hydrogen pumps are energized and charged upon entering the PURGE state. Current to the pumps is limited during initial charging to prevent damage to the power supply. Verify proper charging of the electrochemical hydrogen pumps by monitoring the cell voltages (H2V768-1 thru H2V768-4) and the cell currents (I768-1 thru I768-4); cell potentials should increase steadily to a level of approximately 1.0 VDC while the cell currents should steadily decrease.

- 3) Select the Mode Selection screen on the CDU by depressing the F3 key on the keyboard and select the STANDBY mode. Verify the system transitions from the ON mode PURGE state to the STANDBY mode PURGE state. Return the system to the ON mode and verify the state remains in PURGE.
- 4) Verify the system transitions from the ON mode PURGE state to the ON mode PROCESS-VENT state when the system nitrogen pressure, Item 7062, equals or exceeds the value "STARTP" psia.

5.5.2 PROCESS-VENT State

The following test procedures verify proper transition from the PROCESS-VENT state to the PROCESS state, and demonstrate effector controls applicable to the PROCESS-VENT state.

1) Verify the Item 785, electrolysis power supply, is powered on when the system transitions from the PURGE state to the PROCESS-VENT state.

2) Upon entering the PROCESS-VENT state, the following effector controls are active:

- V003 Recycle Control
- V081-1 Fill Control
- V051A Pressure Control
- Pump 464 Fill Control
- PWR785 On Control
- PS797 On Control

Verification of the correct operation of these controls is described below:

V003 Recycle Control: The feed water accumulator four-way ball valve, Item 003, is set to "FILL1/DRAIN2" if Item 605-2 is the fill tank (V003 is "FILL2/DRAIN1") and the accumulator level LEV605-2 is greater than the tank full limit "HIGHLEV" in³. Conversely, the feed water accumulator four-way ball valve (Item 003) is set to "FILL2/DRAIN1" if Item 605-1 is the fill tank (V003 is "FILL1/DRAIN2") and the accumulator level LEV605-1 is greater than the tank full limit "HIGHLEV" in³.

V081-1 Fill Control: Described in section 5.5.1.

V051A Pressure Control: The facility nitrogen inlet valve, Item 051A, is set to "OPEN" when the nitrogen accumulator pressure, P7062, is less than the minimum pressure limit, "OPENV" psia. The facility nitrogen

inlet valve, Item 051A, is set to "SHUT" when the nitrogen accumulator pressure is greater than the maximum pressure limit, "CLOSEV" psia.

Pump 464 Fill Control: The feed water pump, Item 464, is set to "ON", the feed water pump flow rate is set to "FEEDGPM" gpm, and the feed pump valve, Item 081-2, is set to "OPEN" if the feed water inlet valve, Item 081-1, is "SHUT", and the recirculation water loop metal bellows accumulator level, LEV606, is less than the minimum operating limit, "LOWACC" in³. The feed water pump is set to "OFF", the feed water pump flow rate is set to 0 gpm, and the feed pump valve is set to "SHUT" if the feed water inlet valve is "OPEN" or the recirculation water loop metal bellows accumulator level, LEV606, is greater than the maximum operating limit, "HIGHACC" in³.

PWR785 On Control: The electrolysis power supply, Item 785, is set to "ON" and the current control setting set to "STANDBYT" amps upon entering the PROCESS-VENT state. The current setting is increased "INCREMENTI" amps every "STEPI" seconds until the current equals "NOMI" amps.

PS797 On Control: Described in section 5.5.1.

3) Select the Mode Selection screen on the CDU by depressing the F3 key on the keyboard and select the STANDBY mode. Verify the system transitions from the ON mode PROCESS-VENT state to the STANDBY mode PROCESS-VENT state. Return the system to the ON mode and verify the state remains in PROCESS-VENT.

4) Monitor the nitrogen accumulator pressure, P7062. When the pressure sensor reading equals or exceeds "HIGHLM" psia, the timer "VENTTIME" is initiated. At the end of "VENTTIME" minutes, verify the system transitions from the ON mode PROCESS-VENT state to the ON mode PROCESS state.

5.5.3 PROCESS State

The following test procedures verify proper operation of the system in the PROCESS state, and demonstrate effector controls applicable to the PROCESS state.

1) Upon entering the PROCESS state, the following effector controls are active:

- V003 Recycle Control
- V005 Vent Control
- V081-1 Fill Control
- V051A Pressure Control
- Pump 464 Fill Control
- PWR785 On Control
- PS797 On Control

Verification of the correct operation of these controls is described below:

V003 Recycle Control: Described in section 5.5.2.

V005 Vent Control: The three-way hydrogen solenoid valve, Item 005, defaults to the "VENT" position, delivering product hydrogen gas to the hydrogen vent interface. Select the Assembly Configuration screen on the CDU by depressing the F4 key on the keyboard and select "REDUCTION" for the Hydrogen Delivery configuration; the position of the three-way solenoid valve changes from "VENT" to "PRODUCT", redirecting the flow of hydrogen from the hydrogen vent interface to the hydrogen outlet interface for subsequent delivery to a hydrogen reduction system.

V081-1 Fill Control: Described in section 5.5.1.

V051A Pressure Control: Described in section 5.5.2.

Pump 464 Fill Control: Described in section 5.5.2.

PWR785 On Control: Described in section 5.5.2.

PS797 On Control: Described in section 5.5.1.

5.5.4 HOLD State

The following test procedures verify proper transition from the PROCESS state to the HOLD state, and demonstrate effector controls applicable to the HOLD state.

1) With the system in the ON mode PROCESS state, select the Mode Selection screen on the CDU by depressing the F3 key on the keyboard and select the STANDBY mode. Verify the system transitions from the ON mode PROCESS state to the STANDBY mode HOLD state, and that the three-way solenoid valve position V005 is set to "VENT".

2) Upon entering the HOLD state, the following effector controls are active:

- V003 Recycle Control
- V081-1 Fill Control
- V051A Pressure Control
- Pump 464 Fill Control
- PWR785 On Control
- PS797 On Control

Verification of the correct operation of these controls is described below:

V003 Recycle Control: Described in section 5.5.2.

V081-1 Fill Control: Described in section 5.5.1.

V051A Pressure Control: Described in section 5.5.2.

Pump 464 Fill Control: Described in section 5.5.2.

PWR785 On Control: The electrolysis power supply current setting is instantaneously reduced to "STANDBY" amps. Verify current has been reduced by monitoring the current shunt reading, I766, on the CDU screen.

PS797 On Control: Described in section 5.5.1.

3) Select the Mode Selection screen on the CDU by depressing the F3 key on the keyboard and select the ON mode. Verify the system transitions from the STANDBY mode HOLD state to the ON mode PROCESS state. The electrolysis power supply will increase the current setting "INCREMENT" amps every "STEPI" seconds until the PROCESS current setting is achieved.

5.5.5 RECIRC and OFF States

The following test procedures verify proper transition from the PROCESS state to the RECIRC state, and demonstrate effector controls applicable to the RECIRC state.

1) With the system in the ON mode PROCESS state, select the Mode Selection screen on the CDU and select the OFF mode. Verify the system transitions from the ON mode PROCESS state to the OFF mode RECIRC state. Verify the electrolysis power supply PWR785 is turned off, and a nitrogen purge of the hydrogen circuit has been initiated (V053 is set to "OPEN").

2) The recirculating water pump, Item 463, remains "ON" at a flow setting of "RECIRC" gpm to purge the loop of oxygen gas. After "ACCTIME" minutes, the system transitions from the OFF mode RECIRC state to the OFF mode OFF state, and the recirculating water pump (PMP463) is set to "OFF".

- 3) Select the Mode Selection screen on the CDU and select the IMMEDIATE SHUTDOWN mode. Verify the system transitions from the OFF mode OFF state to the IMMEDIATE SHUTDOWN mode OFF state. Return the system to the OFF mode.

Conducted by: Robert J. Roy Verified by: L. O. Matting

5.6 Performance Test

The purpose of the performance test is to demonstrate continuous and cyclic operation of the SPE OGA, to verify the effectiveness of the refurbishment, and measure system performance parameters such as oxygen production rates, gas quality, and power consumption of the system. The performance test will be divided into two activities: continuous operation and cyclic operation.

5.6.1 Continuous system operation

The system will be run continuously to demonstrate variable oxygen production capability of the refurbished SPE OGA, measure the purity of the oxygen and hydrogen gases produced, demonstrate optional delivery to the hydrogen outlet interface for possible use by a CO₂ reduction system, and verify proper system restart following a loss of power shutdown.

- 1) Turn the power to the system and the CDU on. Verify the system is in the OFF mode OFF state. Measure system power while in the OFF state and record in Appendix A.
- 2) Select the Assembly Configuration screen on the CDU by depressing the F4 key on the keyboard. Verify the Oxygen Delivery configuration is set to "CONTINUOUS" and the Hydrogen Delivery configuration is set to "VENT", the respective default settings.

- 3) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Verify the Oxygen Requirement is 7.40 lb/day, the default oxygen production rate. Verify the Light Side duration is 54 minutes, and the Dark Side duration is 36 minutes, the respective default settings (NOTE: Since the Oxygen Delivery configuration is set to "CONTINUOUS", the system controller will not change ~~states from the PROCESS state to the HOLD state~~ ^{the current level to the electrolysis module 12-key 4-25-95} after 54 minutes of operation).
- 4) Select the Mode Selection screen on the CDU by depressing the F3 key on the keyboard. Select the ON mode. Verify the system transitions from the OFF mode OFF state to the ON mode PURGE state. Verify the PURGE state transitions to the PROCESS-VENT state, and finally to the PROCESS state. Measure power while in the PURGE state, the PROCESS-VENT state and the PROCESS state and record in Appendix A.
- 5) While the system is in the PROCESS-VENT and PROCESS state, note the quality of the exiting oxygen and hydrogen gases. Verify both streams are free of liquid water, especially at the beginning of PROCESS-VENT. The hydrogen phase separator has been refurbished to preclude water carry-over during system start-up transient conditions.
- 6) The refurbished SPE OGA incorporates a liquid-to-liquid heat exchanger that has sufficient capacity to reject the waste heat generated by electrolysis cells operating at a maximum potential of 2.5 Vdc per cell. Monitor performance of the liquid-to-liquid heat exchanger throughout the conduct of this test program to ensure adequate heat rejection at all operating conditions. With cooling water flowing through the heat exchanger at a flow rate of 500 lb/hr (1 gpm) and an inlet temperature of 65°F, the temperature of the two-phase fluid stream exiting the heat exchanger should not exceed 70°F.
- 7) Attach a wet test meter or other flow measurement device to the oxygen outlet and hydrogen vent interface. Measure and record the oxygen and hydrogen flow rates and calculate the mass flow rate in lb/day.

Verify the oxygen production rate is 7.40 lb/day, minimum, and the hydrogen production rate is 0.93 lb/day, or one-eighth the oxygen rate. Include any calculations in Appendix B.

8) Attach sample cylinders or other sampling device to the oxygen outlet and hydrogen vent interface and obtain samples of each gas. Analyze the oxygen for hydrogen and the hydrogen for oxygen. Record the results in Appendix C.

9) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Change the Oxygen Requirement from 7.40 lb/day to the minimum requirement of 6.66 lb/day. Verify the current setting to the electrolysis cell stack has been reduced (I766).

9) Attach a wet test meter or other flow measurement device to the oxygen outlet and hydrogen vent interface. Measure and record the oxygen and hydrogen flow rates and calculate the mass flow rate in lb/day. Verify the oxygen production rate is 6.66 lb/day, minimum, and the hydrogen production rate is 0.83 lb/day, or one-eighth the oxygen rate. Include any calculations in Appendix B.

10) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Change the Oxygen Requirement from 6.66 lb/day to the maximum requirement of 8.14 lb/day. Verify the current setting to the electrolysis cell stack has been increased (I766).

11) Attach a wet test meter or other flow measurement device to the oxygen outlet and hydrogen vent interface. Measure and record the oxygen and hydrogen flow rates and calculate the mass flow rate in lb/day. Verify the oxygen production rate is 8.14 lb/day, minimum, and the hydrogen production rate is 1.02 lb/day, or one-eighth the oxygen rate. Include any calculations in Appendix B.

12) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Change the Oxygen Requirement from 8.14 lb/day to the nominal requirement of 7.40 lb/day. Verify the current setting to the electrolysis cell stack has been reduced (I766).

13) Select the Assembly Configuration screen on the CDU by depressing the F4 key on the keyboard. Change the Hydrogen Delivery configuration to "REDUCTION". Verify the hydrogen delivery is diverted from the hydrogen vent interface to the hydrogen outlet interface, and V005 has switched from "VENT" to "PRODUCT".

14) Adjust the hydrogen back pressure regulator on the test panel until the hydrogen pressure at the regulator is 25 psig, the maximum back pressure expected for delivery of hydrogen to a CO₂ reduction system. Verify no hydrogen flow at the hydrogen vent interface. Monitor performance of the Item 005 valve during the conduct of the acceptance program; prior testing of the OGA resulted in failure of the solenoid coil in the valve due to operating temperatures which exceeded the maximum design temperature. The valve has since been modified to reduce the operating voltage once the valve has been actuated.

15) The recirculating water loop in the original Technology Demonstrator system experienced pump priming problems at start-up. The refurbishment of the system addressed this problem by reducing the operating pressure of the loop, minimizing pressure drop within the loop, and operating the recirculating water loop bellows accumulator with a fixed nitrogen charge such that the pump inlet never operates at subambient pressure. Verify the effectiveness of the refurbishment by removing power to the EIB, thereby initiating a loss of power shutdown. After approximately 10 seconds, return power to the EIB and verify the system is in the OFF mode OFF state. Select the Mode Selection screen and select the ON mode. Verify the system transitions from the OFF mode OFF state to the ON mode PURGE state. Verify the recirculation pump, Item 463, operates correctly by monitoring the status of the flow

switch, Item 745, and by observing pressure drop DP709 across the oxygen phase separator assembly, Item 907.

16) Repeat a loss of power shutdown, followed by a system restart, a minimum of 5 times to confirm proper pump priming.

Conducted by: Robert J. Roy Verified by: L. C. Moulthrop

5.6.2 Cyclic system operation

The SPE OGA will be operated cyclically to demonstrate the ability of the system to produce the daily requirement of oxygen while operating only on the light side of the space station orbit. The system will transition to a HOLD state when the dark side of the orbit is simulated, with only a trickle current provided to the electrolysis cell stack to maintain pressure control of the hydrogen system and to offset diffusion losses. System instrumentation and operation of the pumps is also active during the dark side operation. Variable oxygen production capability and the ability of the system to deliver hydrogen to the outlet interface for possible use by a CO₂ reduction system will be demonstrated with the system operating in a cyclical mode.

- 1) Turn the power to the system and the CDU on. Verify the system is in the OFF mode OFF state.
- 2) Select the Assembly Configuration screen on the CDU by depressing the F4 key on the keyboard. Set the Oxygen Delivery configuration to "PERIODIC" and the Hydrogen Delivery configuration to "REDUCTION".
- 3) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Verify the Oxygen Requirement is 7.40 lb/day, the default oxygen production rate. Verify the Light Side duration is 54 minutes, and the Dark Side duration is 36 minutes, the respective default settings.

4) Select the Mode Selection screen on the CDU by depressing the F3 key on the keyboard. Select the ON mode. Verify the system transitions from the OFF mode OFF state to the ON mode PURGE state. Verify the PURGE state transitions to the PROCESS-VENT state, and finally to the PROCESS state. Measure power while in the PROCESS-VENT state and the PROCESS state and record in Appendix A.

5) Attach a wet test meter or other flow measurement device to the oxygen outlet and hydrogen vent interface. Measure and record the oxygen and hydrogen flow rates and calculate the mass flow rate in lb/day. Verify the oxygen production rate is 12.33 lb/day (7.4 lb/day at a duty cycle of 60%), minimum, and the hydrogen production rate is 1.54 lb/day, or one-eighth the oxygen rate. Include any calculations in Appendix B.

6) After operating in the PROCESS mode for 54 minutes, verify the ~~system transitions from the ON mode PROCESS state to the STANDBY mode HOLD state. Verify the current to the electrolysis cell stack is reduced to "STANDBY" amps, and the hydrogen delivery valve diverts flow to the hydrogen vent interface (V005 - "VENT").~~ After 36 minutes, verify the ~~system transitions from the STANDBY mode HOLD state to the ON mode PROCESS state. Verify the current to the electrolysis cell stack returns to its original value and the hydrogen delivery valve diverts flow to the hydrogen outlet interface (V005 - "PRODUCT").~~ Operate the system for a minimum of two more cycles at these operating conditions.

NOTE: SYSTEM DESIGNED TO REMAIN IN PROCESS STATE REGARDLESS OF CURRENT LEVEL. IN ADDITION, WE DECIDED TO LEAVE IT ON 0.5 IN ITS CURRENT CONFIGURATION REGARDLESS OF DARK/LIGHT ORIENTATION. R-Pry

7) Repeat steps 1-6 at the minimum oxygen requirement of 6.66 lb/day, ^{4/28/95} and at the maximum value of 8.14 lb/day.

8) With the system operating at the oxygen requirement of 8.14 lb/day, initiate a loss of power shutdown by removing power to the EIB. Return power to the EIB and verify the system is in the OFF mode OFF state.

9) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Verify the Oxygen Requirement is reset to 7.40 lb/day. Select the Assembly Configuration screen on the CDU by

depressing the F4 key on the keyboard. Verify the Oxygen Delivery and Hydrogen Delivery have returned to their default values of "CONTINUOUS" and "VENT", respectively. Select "PERIODIC" for the Oxygen Delivery configuration, and "REDUCTION" for the Hydrogen Delivery configuration.

10) Select the Mode Selection screen on the CDU by depressing the F3 key on the keyboard and select the ON mode. Verify the system transitions from the OFF mode OFF state to the ON mode PURGE state. Verify the recirculation pump, Item 463, operates correctly by monitoring the status of the flow switch, Item 745, and by observing pressure drop DP709 across the oxygen phase separator assembly, Item 907.

11) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Enter 60 minutes for Light Side, and 30 minutes for Dark Side.

12) Once the system transitions to the ON mode PROCESS state, verify the state remains in PROCESS for 60 minutes. Measure and record the oxygen flow rate and calculate the mass flow rate in lb/day. Include any calculations in Appendix B. Verify the oxygen production rate is 11.10 lb/day (7.4 lb/day at a duty cycle of 66%), minimum. Verify the system ~~transitions from the ON mode PROCESS state to the STANDBY mode~~ ^{CURRENT LEVEL TO THE ELECTROLYSIS MODULE IS REDUCED TO "STANDBY" (AMPS)} ~~HOLD state after the 60 minute period. Verify the system transitions~~ ^{CURRENT LEVEL} ~~from the STANDBY mode HOLD state to the ON mode PROCESS state~~ ^{RETURNS TO ITS ORIGINAL VALUE} ~~after 30 minutes in the HOLD state.~~ ^{AT "STANDBY" (AMPS) (SEE NOTE ON PAGE 43, PARA 6)}

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13) After a minimum of 2 cycles at this duty cycle, select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Enter 54 minutes for Light Side, and 36 minutes for Dark Side. Continue cyclic testing of the system until 3 days prior to the system ship date.

14) At the conclusion of testing, select the Mode Selection screen on the CDU and select the OFF mode. Verify the system transitions from either

the ON mode PROCESS state, or the STANDBY mode HOLD state, to the OFF mode OFF state.

Conducted by: Robert J. Roy Verified by: Lawrence C. Montenegro

5.7 **Final Testing**

Final testing of the system is conducted to verify the unit is ready for delivery to the customer.

5.7.1 **Verification of system parameters**

1) Turn the power to the system and the CDU on. Verify the system is in the OFF mode OFF state.

2) Select the Assembly Configuration screen on the CDU by depressing the F4 key on the keyboard. Verify the Oxygen Delivery and Hydrogen Delivery configurations are set at their default settings of "CONTINUOUS" and "VENT", respectively.

3) Select the Modify/View Operation screen on the CDU by depressing the F6 key on the keyboard. Verify the Oxygen Requirement is set at its default setting of 7.40 lb/day, and the Light Side and Dark Side settings are at ~~54~~ and ~~36~~ minutes, respectively.

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4) Select pages 2 and 3 of the Modify/View Operation screen on the CDU by depressing the F1 key on the keyboard. Review the setpoint values and compare with those listed in the CDU Setpoint Input Communication Data Packet tables of the Process Controller SRS. Resolve any discrepancies between the values displayed and those in the table.

Conducted by: Robert J. Roy Verified by: Lawrence C. Montenegro

DATE: 16-JUN-95
MODE: OFF

SPE OGA
STATE: OFF

TIME: 13:53:07
STATUS: NORMAL

TOTAL OPERATION TIME: 0.0 HRS OXYGEN PRODUCTION RATE: 0.00 LB/DAY
ELECTROLYSIS DUTY CYCLE: 100 % HYDROGEN PRODUCTION RATE: 0.00 LB/DAY

STANDBYI	1.0	INCREMENTI	5.0	STEPI	5.0
RECIRC	0.60	ACCTIME	2.0	HIGHO2SEP	10.0
FEEDGFM	0.024	LOWACC	10.5	HIGHACC	13.0
LOWLEV	6.5	MEDLEV	10.5	HIGHLEV	25.0
STARTP	50.0	HIGHLIM	70.0	N2PTIME	2.0
AMBFPRESS	30.0	OPENV	73.0	CLOSEV	75.0
VENTTIME	1.0	H2CELLV	0.9	H2CVTIME	60.0

CURRENT VALUE: 1.0000
ANOMALY:
ADVICE:

NEW VALUE:

[F1] PAGE [F4] ASSY CNFG [F7] ACKNOWLEDGE [F10] MODIFY OPER
[F2] SUBSYSTEM PARA [F5] MANUAL OPER [F8] DATA LOGGING [F11] EFFECTOR CNFG
[F3] MODE SELECTION [F6] VIEW OPER [F9] EXIT PAGE 2 OF 3

DATE: 16-JUN-95
MODE: OFF

SPE OGA
STATE: OFF

TIME: 13:53:07
STATUS: NORMAL

TOTAL OPERATION TIME: 0.0 HRS OXYGEN PRODUCTION RATE: 0.00 LB/DAY
ELECTROLYSIS DUTY CYCLE: 100 % HYDROGEN PRODUCTION RATE: 0.00 LB/DAY

O2FAIL1	18.0	O2FAIL2	30.0	DEPRES1	25.0
HIGHN2P	85.0	LEAKTIME	55.0	LEAKTIME2	3.0
HIGHH2P	50.0	LOWH2P	25.0	DELTIME	2.0
HIGHH2SEP1	10.0	HIGHH2SEP2	14.0	T6	40.0
H2SEP	3.0	LOWH2SEP	1.0	T5	30.0
LOWO2SEP	1.0	T3	30.0	T7	10.0
HIGHSDACC	45.0	HIGHSDLEV	30.0	HIMEDLEV	24.0
LOWSDLEV	2.0	T8	10.0	CVGASTOL	7.0
CVRATE	5.0	HIGHCOND	10.0	FILLTIME	5.0
HIGHCELL	2.5	HIGHPUMP	1.3	LOWPUMP	0.1
VTIME	20.0				

CURRENT VALUE: 18.0000
ANOMALY:
ADVICE:

NEW VALUE:

[F1] PAGE [F4] ASSY CNFG [F7] ACKNOWLEDGE [F10] MODIFY OPER
[F2] SUBSYSTEM PARA [F5] MANUAL OPER [F8] DATA LOGGING [F11] EFFECTOR CNFG
[F3] MODE SELECTION [F6] VIEW OPER [F9] EXIT PAGE 3 OF 3

5.7.2 Post-test visual inspection

Inspect the system for any obvious defects due to improper handling during acceptance testing of the unit, or any improper wear of system components. Correct and/or repair any defects prior to shipment.

Conducted by: Robert J. Roy Verified by: Lawrence C. Moulthrop

5.7.3 System weight

Prior to shipment, weigh the SPE OGA system package, and the electrolysis power supply cart. Record in the space below.

System package: 383 lb
Power supply cart: 291 lb.

Conducted by: Robert J. Roy Verified by: Lawrence C. Moulthrop

APPENDIX A SYSTEM POWER REQUIREMENTS

SYSTEM POWER REQUIREMENTS

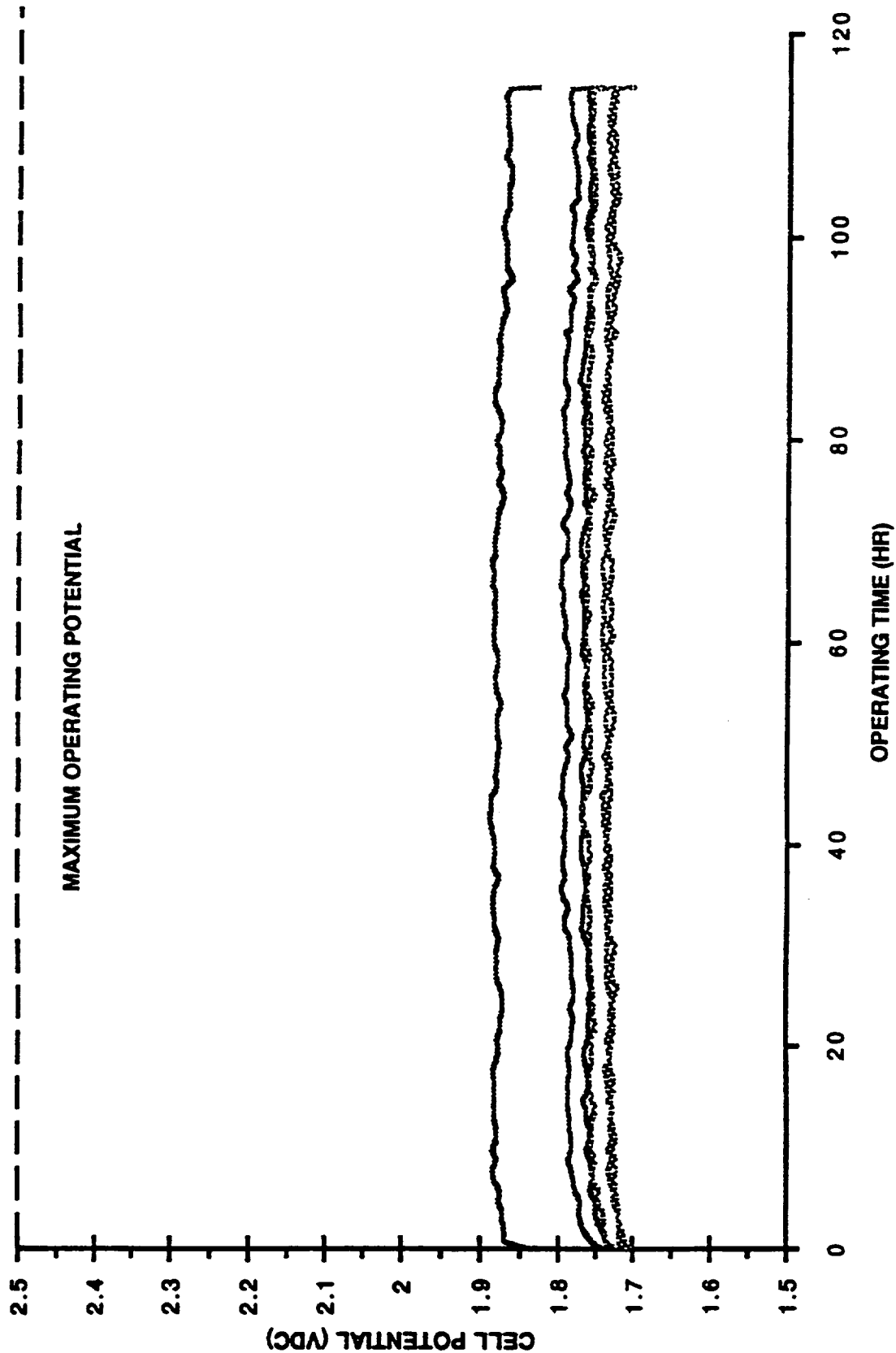
SYSTEM CONFIGURATION			115 VAC, 60 HZ						28 VAC, 60 HZ					
			STACK PERFORMANCE			PHASE A			PHASE B			PHASE C		
MODE	STATE	REQUIREMENT (Amps)	CALLING (VDC)	CURRENT (AMPS)	POWER (WATTS)	POTENTIAL (VAC)	CURRENT (AMPS)	POWER (WATTS)	POTENTIAL (VAC)	CURRENT (AMPS)	POWER (WATTS)	POTENTIAL (VAC)	CURRENT (AMPS)	POWER (WATTS)
MANUAL	OFF	N/A	-	-	-	115	1.1					28	0.45	
	ETB													
	003					115	0.2							
	005					115	0.2							
	051					115	0.2							
	051A					115	0.2							
	053					115	0.2							
	081-1					115	0.2							
	463													
	463 464													
OFF	OFF					115	1.0							
ON	PURGE	7.4	(463 ON)			115	1.7					28	2.5	
ON	PURGE	7.4	(051A ON)			115	1.8					28	2.5	
ON	PURGE	7.4	(053 START)			115	2.0					28	2.5	
ON	PROCESS	7.4		26		115	4.8		115	2.8		115	2.9	
ON	PROCESS	7.4		26		115	4.9		115	2.8		115	2.9	
ON	PROCESS	7.4												
	60% ON		1861	44		115	6.8		115	4.9		115	5.0	
REMOVING	PURGE WITH DVM IN MANUAL MODE													
MANUAL	OFF					115	1.04							
	ETB													
	003					115	0.15					28	0.45	
	005					115	0.16							
	051					115	0.12							
	051A					115	0.28							
	053					115	0.18							
	081-1					115	0.18							
	463 (LOW GAIN)											28	2.1	
	463 464											28	2.7	

SYSTEM POW. REQUIREMENTS

[illegible]

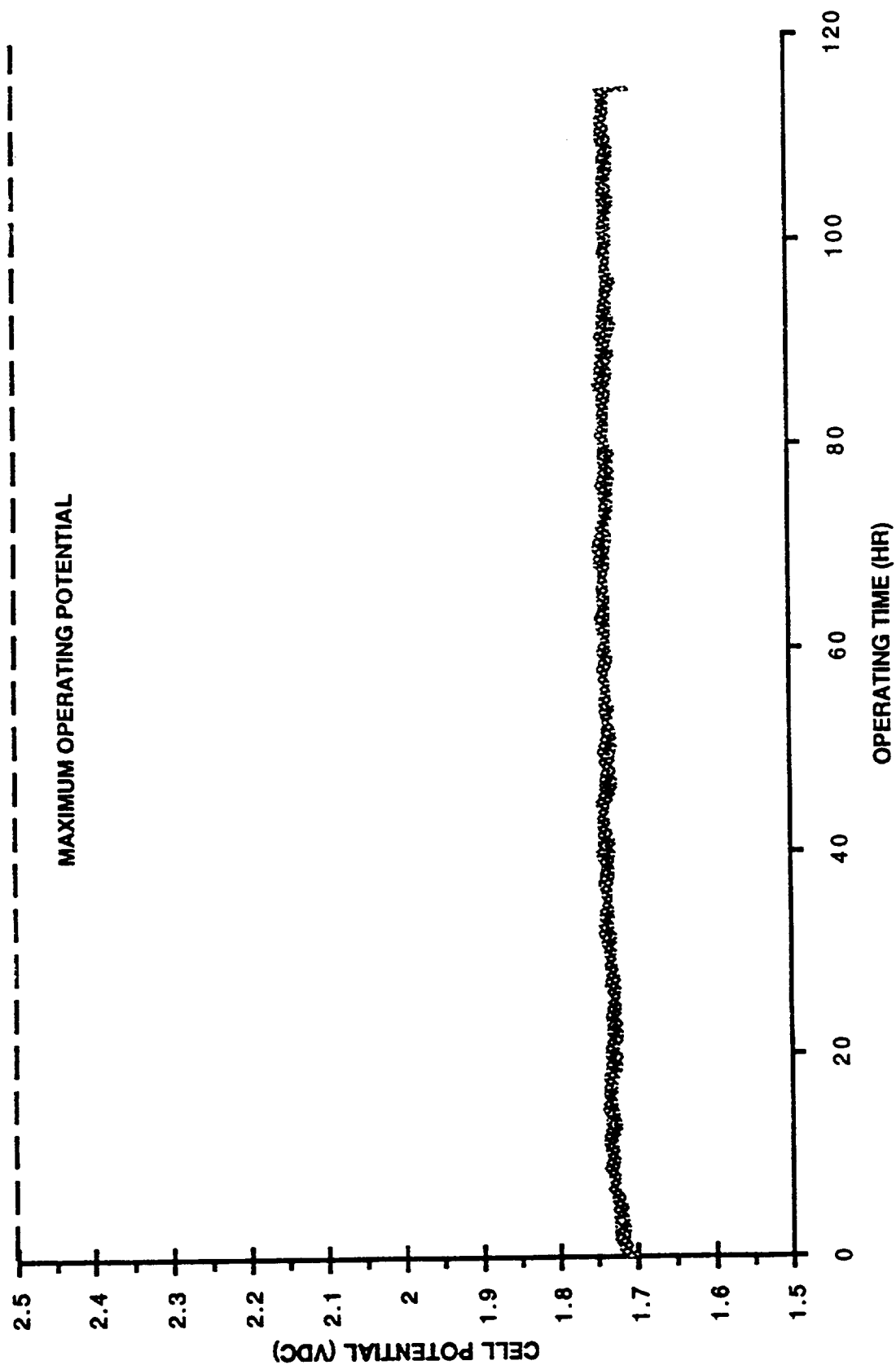
SPE OGA
18-CELL STACK
90°F -- 50 AMPS
CELLS 1-6

3/15/95



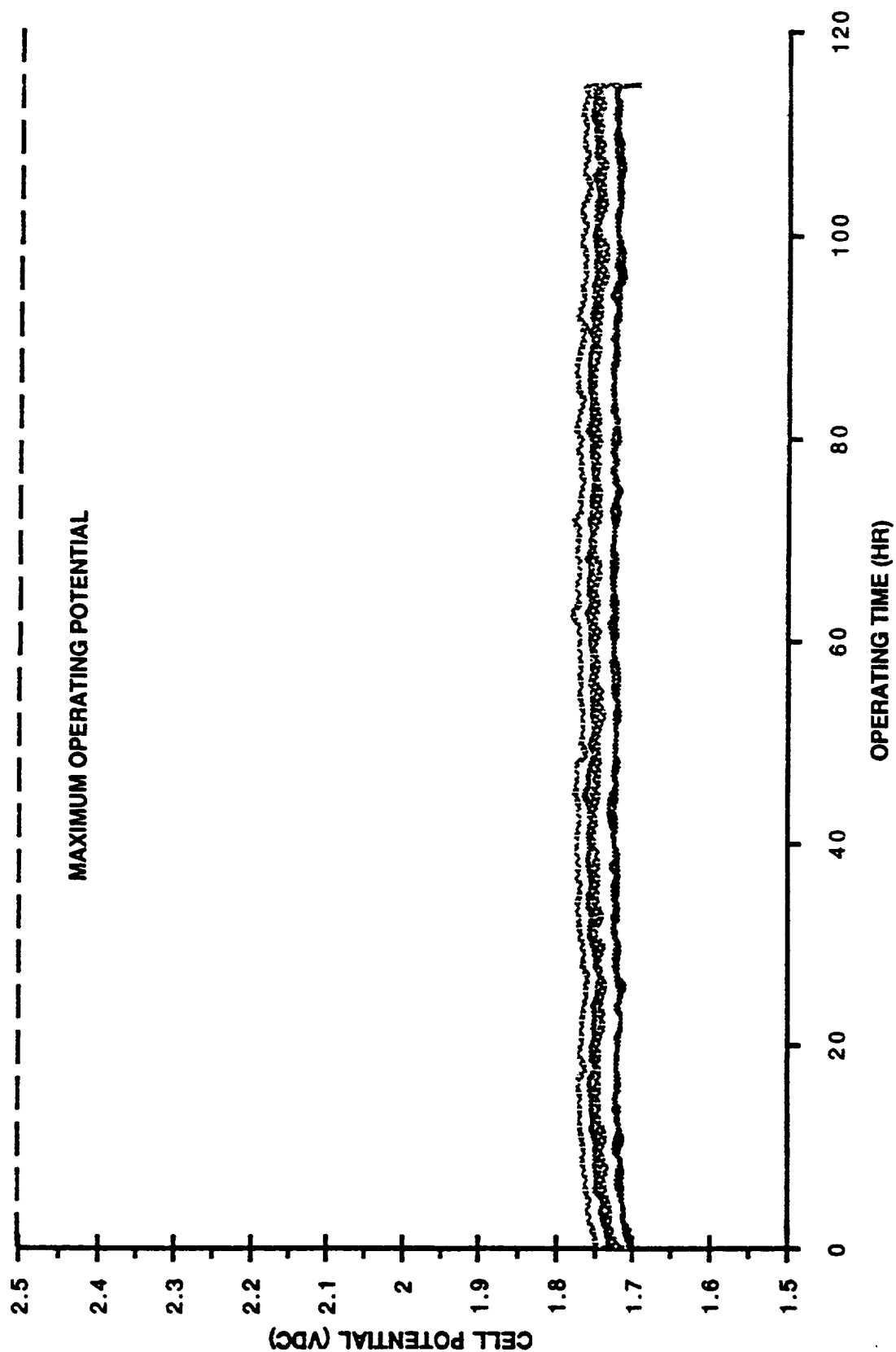
3/15/95

SPE OGA
18-CELL STACK
90°F -- 50 AMPS
CELLS 7-12



3/15/95

SPE OGA
18-CELL STACK
90°F -- 50 AMPS
CELLS 13-18



APPENDIX B GAS PRODUCTION RATE CALCULATIONS

$$O_2 \text{ (LB/DAY)} = [(CFM, \text{measured})(P - P_{vap}) / (R)(T + 460)](32 \text{ lb/lb-mole})(60 \text{ min/hr})(24 \text{ hr/day})$$

$$H_2 \text{ (LB/DAY)} = [(CFM, \text{measured})(P - P_{vap}) / (R)(T + 460)](2 \text{ lb/lb-mole})(60 \text{ min/hr})(24 \text{ hr/day})$$

where:

CFM = gas volumetric flow rate (cubic feet/minute)

P = barometric + wet test meter manometer pressure (psia)

P_{vap} = vapor pressure of water at temperature T (psia)

R = universal gas constant = 10.73 psia - cubic ft / lb mole · °R

T = gas temperature in meter (°F)

TEST REF.	O ₂					H ₂				
	FLOW (CFM)	P (PSIA)	T (°F)	P_{vap} (PSIA)	FLOW (LB/DAY)	FLOW (CFM)	P (PSIA)	T (°F)	P_{vap} (PSIA)	FLOW (LB/DAY)
5.6.1 PARA 7	.0676	14.40	24°C/75°F	0.43	7.58	.1359	14.53	80	0.51	0.947
5.6.1 PARA 9	.0611	14.40	25°C/77°F	0.46	6.81	.1223	14.53	80	0.51	0.852
5.6.1 PARA 11	.0739	14.40	25°C/77°F	0.46	8.24	.1496	14.53	80	0.51	1.043
5.6.1 PARA 14	—	—	—	—	—	0.1360	14.52	80	0.51	0.947 *
5.6.2 PARA 5	.1156	14.40	29°C/84°F	.58	12.61	.2243	14.48	80	0.51	1.56
5.6.2 PARA 7	.1019	14.43	80°F	.51	11.28	.2022	14.48	80	0.51	1.40
5.6.2 PARA 7	.1239	14.43	80°F	.51	13.72	.2464	14.48	80	0.51	1.71
5.6.2 PARA 12	.1015	14.43	78°F	.47	11.31	—	—	—	—	—

* MEASURED @ 25 psig BACK PRESSURE AT TEST PANEL.
NO H₂ BUBBLES OBSERVED @ H₂ VENT INTERFACE.
(REFERENCE SECTION 5.6.1 PARA 13-14)

Table 1. Saturated Steam: Temperature Table

Temp Fahr t	Abs Press. Lb per Sq. In. p	Specific Volume			Enthalpy ΔT in $^{\circ}\text{F}$			Entropy			Temp Fahr t
		Sat. Liquid v_f	Evap v_{fg}	Sat. Vapor v_g	Sat. Liquid h_f	Evap h_{fg}	Sat. Vapor h_g	Sat. Liquid s_f	Evap s_{fg}	Sat. Vapor s_g	
32.0*	0.08859	0.016022	3304.7	3304.7	-0.0179	1075.5	1075.5	0.0000	2.1873	2.1873	32.0*
34.0	0.09600	0.016021	3061.9	3061.9	1.996	1074.4	1076.4	0.0041	2.1762	2.1802	34.0
36.0	0.10395	0.016020	2839.0	2839.0	4.008	1073.2	1077.2	0.0081	2.1651	2.1732	36.0
38.0	0.11249	0.016019	2634.1	2634.2	6.018	1072.1	1078.1	0.0122	2.1541	2.1663	38.0
40.0	0.12163	0.016019	2445.8	2445.8	8.027	1071.0	1079.0	0.0162	2.1432	2.1594	40.0
42.0	0.13143	0.016019	2272.4	2272.4	10.035	1069.8	1079.9	0.0202	2.1325	2.1527	42.0
44.0	0.14192	0.016019	2112.8	2112.8	12.041	1068.7	1080.7	0.0242	2.1217	2.1459	44.0
46.0	0.15314	0.016020	1965.7	1965.7	14.047	1067.6	1081.6	0.0282	2.1111	2.1393	46.0
48.0	0.16514	0.016021	1830.0	1830.0	16.051	1066.4	1082.5	0.0321	2.1006	2.1327	48.0
50.0	0.17796	0.016023	1704.8	1704.8	18.054	1065.3	1083.4	0.0361	2.0901	2.1262	50.0
52.0	0.19165	0.016024	1589.2	1589.2	20.057	1064.2	1084.2	0.0400	2.0798	2.1197	52.0
54.0	0.20625	0.016026	1482.4	1482.4	22.058	1063.1	1085.1	0.0439	2.0695	2.1134	54.0
56.0	0.22183	0.016028	1383.6	1383.6	24.059	1061.9	1086.0	0.0478	2.0593	2.1070	56.0
58.0	0.23843	0.016031	1292.2	1292.2	26.060	1060.8	1086.9	0.0516	2.0491	2.1008	58.0
60.0	0.25611	0.016033	1207.6	1207.6	28.060	1059.7	1087.7	0.0555	2.0391	2.0946	60.0
62.0	0.27494	0.016036	1129.2	1129.2	30.059	1058.5	1088.6	0.0593	2.0291	2.0885	62.0
64.0	0.29497	0.016039	1056.5	1056.5	32.058	1057.4	1089.5	0.0632	2.0192	2.0824	64.0
66.0	0.31626	0.016043	989.0	989.1	34.056	1056.3	1090.4	0.0670	2.0094	2.0764	66.0
68.0	0.33889	0.016046	926.5	926.5	36.054	1055.2	1091.2	0.0708	1.9996	2.0704	68.0
70.0	0.36292	0.016050	868.4	868.4	38.052	1054.0	1092.1	0.0745	1.9900	2.0645	70.0
72.0	0.38844	0.016054	814.3	814.3	40.049	1052.9	1093.0	0.0783	1.9804	2.0587	72.0
74.0	0.41550	0.016058	764.1	764.1	42.046	1051.8	1093.8	0.0821	1.9708	2.0529	74.0
76.0	0.44420	0.016063	717.4	717.4	44.043	1050.7	1094.7	0.0858	1.9614	2.0472	76.0
78.0	0.47461	0.016067	673.8	673.9	46.040	1049.5	1095.6	0.0895	1.9520	2.0415	78.0
80.0	0.50683	0.016072	633.3	633.3	48.037	1048.4	1096.4	0.0932	1.9426	2.0359	80.0
82.0	0.54093	0.016077	595.5	595.5	50.033	1047.3	1097.3	0.0969	1.9334	2.0303	82.0
84.0	0.57702	0.016082	560.3	560.3	52.029	1046.1	1098.2	0.1006	1.9242	2.0248	84.0
86.0	0.61518	0.016087	527.5	527.5	54.026	1045.0	1099.0	0.1043	1.9151	2.0193	86.0
88.0	0.65551	0.016093	496.8	496.8	56.022	1043.9	1099.9	0.1079	1.9060	2.0139	88.0
90.0	0.69813	0.016099	468.1	468.1	58.018	1042.7	1100.8	0.1115	1.8970	2.0086	90.0
92.0	0.74313	0.016105	441.3	441.3	60.014	1041.6	1101.6	0.1152	1.8881	2.0033	92.0
94.0	0.79062	0.016111	416.3	416.3	62.010	1040.5	1102.5	0.1188	1.8792	1.9980	94.0
96.0	0.84072	0.016117	392.8	392.9	64.006	1039.3	1103.3	0.1224	1.8704	1.9928	96.0
98.0	0.89356	0.016123	370.9	370.9	66.003	1038.2	1104.2	0.1260	1.8617	1.9876	98.0
100.0	0.94924	0.016130	350.4	350.4	67.999	1037.1	1105.1	0.1295	1.8530	1.9825	100.0
102.0	1.00789	0.016137	331.1	331.1	69.995	1035.9	1105.9	0.1331	1.8444	1.9775	102.0
104.0	1.06965	0.016144	313.1	313.1	71.992	1034.8	1106.8	0.1366	1.8358	1.9725	104.0
106.0	1.1347	0.016151	296.16	296.18	73.99	1033.6	1107.6	0.1402	1.8273	1.9675	106.0
108.0	1.2030	0.016158	280.28	280.30	75.98	1032.5	1108.5	0.1437	1.8188	1.9626	108.0
110.0	1.2750	0.016165	265.37	265.39	77.98	1031.4	1109.3	0.1472	1.8105	1.9577	110.0
112.0	1.3505	0.016173	251.37	251.38	79.98	1030.2	1110.2	0.1507	1.8021	1.9528	112.0
114.0	1.4299	0.016180	238.21	238.22	81.97	1029.1	1111.0	0.1542	1.7938	1.9480	114.0
116.0	1.5133	0.016188	225.84	225.85	83.97	1027.9	1111.9	0.1577	1.7856	1.9433	116.0
118.0	1.6009	0.016196	214.20	214.21	85.97	1026.8	1112.7	0.1611	1.7774	1.9386	118.0
120.0	1.6927	0.016204	203.25	203.26	87.97	1025.6	1113.6	0.1646	1.7693	1.9339	120.0
122.0	1.7891	0.016213	192.94	192.95	89.96	1024.5	1114.4	0.1680	1.7613	1.9293	122.0
124.0	1.8901	0.016221	183.23	183.24	91.96	1023.3	1115.3	0.1715	1.7533	1.9247	124.0
126.0	1.9959	0.016229	174.08	174.09	93.96	1022.2	1116.1	0.1749	1.7453	1.9202	126.0
128.0	2.1068	0.016238	165.45	165.47	95.96	1021.0	1117.0	0.1783	1.7374	1.9157	128.0
130.0	2.2230	0.016247	157.32	157.33	97.96	1019.8	1117.8	0.1817	1.7295	1.9112	130.0
132.0	2.3445	0.016256	149.64	149.66	99.95	1018.7	1118.6	0.1851	1.7217	1.9068	132.0
134.0	2.4717	0.016265	142.40	142.41	101.95	1017.5	1119.5	0.1884	1.7140	1.9024	134.0
136.0	2.6047	0.016274	135.55	135.57	103.95	1016.4	1120.3	0.1918	1.7063	1.8980	136.0
138.0	2.7438	0.016284	129.09	129.11	105.95	1015.2	1121.1	0.1951	1.6986	1.8937	138.0
140.0	2.8892	0.016293	122.98	123.00	107.95	1014.0	1122.0	0.1985	1.6910	1.8895	140.0
142.0	3.0411	0.016303	117.21	117.22	109.95	1012.9	1122.8	0.2018	1.6834	1.8852	142.0
144.0	3.1997	0.016312	111.74	111.76	111.95	1011.7	1123.6	0.2051	1.6759	1.8810	144.0
146.0	3.3653	0.016322	106.58	106.59	113.95	1010.5	1124.5	0.2084	1.6684	1.8769	146.0
148.0	3.5381	0.016332	101.68	101.70	115.95	1009.3	1125.3	0.2117	1.6610	1.8727	148.0
150.0	3.7184	0.016343	97.05	97.07	117.95	1008.2	1126.1	0.2150	1.6536	1.8686	150.0
152.0	3.9065	0.016353	92.64	92.66	119.95	1007.0	1126.9	0.2183	1.6463	1.8644	152.0
154.0	4.1025	0.016363	88.50	88.52	121.95	1005.8	1127.7	0.2216	1.6390	1.8606	154.0
156.0	4.3068	0.016374	84.56	84.57	123.95	1004.6	1128.6	0.2248	1.6318	1.8566	156.0
158.0	4.5197	0.016384	80.82	80.83	125.96	1003.4	1129.4	0.2281	1.6245	1.8526	158.0
160.0	4.7414	0.016395	77.27	77.29	127.96	1002.2	1130.2	0.2313	1.6174	1.8487	160.0
162.0	4.9722	0.016406	73.90	73.92	129.96	1001.0	1131.0	0.2345	1.6103	1.8448	162.0
164.0	5.2124	0.016417	70.70	70.72	131.96	999.8	1131.8	0.2377	1.6032	1.8409	164.0
166.0	5.4623	0.016428	67.67	67.68	133.97	998.6	1132.6	0.2409	1.5961	1.8371	166.0
168.0	5.7223	0.016440	64.78	64.80	135.97	997.4	1133.4	0.2441	1.5892	1.8333	168.0
170.0	5.9926	0.016451	62.04	62.06	137.97	996.2	1134.2	0.2473	1.5822	1.8295	170.0
172.0	6.2736	0.016463	59.43	59.45	139.98	995.0	1135.0	0.2505	1.5753	1.8258	172.0
174.0	6.5656	0.016474	56.95	56.97	141.98	993.8	1135.8	0.2537	1.5684	1.8221	174.0
176.0	6.8690	0.016486	54.59	54.61	143.99	992.6	1136.6	0.2568	1.5616	1.8184	176.0
178.0	7.1840	0.016498	52.35	52.36	145.99	991.4	1137.4	0.2600	1.5548	1.8147	178.0

*The states shown are metastable

APPENDIX C GAS PURITY

HSF-86, 1H 4/78

REQUEST FOR LABORATORY WORK

THIS SECTION TO BE
COMPLETED BY ORIGINATOR

LABORATORY NO.

FROM DEPT. - #	REQUESTED BY B. Roy	TEL EXT	DATE	WORK ORDER #	DATE RECEIVED 4-28-95
PART NO.	PART NAME PRE-OGA			PMP OR SPEC	ANALYST BMP
LOT OR SER. #	REQUEST FOR H2O2			QUANTITY 2	DATE COMPLETED 4-28-95

TEST REQUIREMENTS (1 PER LINE)

RESULTS

Hydrogen

<500 ppm O2

Oxygen

<0.5% H2

**APPENDIX D
TEST ANOMALIES**



DATE 01-MAR-95

DATE 01-MAR-95

Failure of OGA components shall be detected according to the Fault Detection State Definition Table 4 – LIX based on the OGA operating state (STATE).

[illegible][illegible]

ANOMALY 7c)
(Def. PAIA.

[illegible]

The anomaly list (ANOMALY_LIST) shall[2] be augmented with an integer word list of all active OGA anomalies per the anomaly codes listed in Table 4 – LX. A single integer for normal status (code 500) shall[3] be used for the anomaly list (ANOMALY_LIST) if no anomalies are active.

TABLE 4--LX ANOMALY LIST CODE TABLE

BUILT-IN-TEST NAME	PRIORITY WITHIN LEVEL	ACTIVE CODE FOR "LEVEL 1"	ACTIVE CODE FOR "LEVEL 2"
C0704_1 FAULT	1	101	201
C0704_2 FAULT	2	102	202
C0704_3 FAULT	3	103	203
C0704_4 FAULT	4	104	204
T702_1 FAULT	5	105	205
T702_2 FAULT	6	106	206
V7000 LO FAULT	7	-	107
T700 HI FAULT	8	-	208
V7000 HI FAULT	9	-	209
HV700 LO FAULT	10	-	210
HV700 HI FAULT	11	-	211
T701 DIFF FAULT	12	-	212
P700 LO FAULT	13	-	213
P700 HI FAULT	14	-	214
P701 HI FAULT	15	107	215
C0704 LO FAULT	16	-	216

DATE	ANOMALY	ACTION TAKEN
4-17-95	CODE 220 - H ₂ SUPPLY VALVE (ITEM 051A) IS OPEN TOO LONG	CHANGED VARIABLE "LEAKTIME2" FROM 1.5 MINUTES TO 3.0 MINUTES - LONGER TIME NEEDED DUE TO DROP OF H ₂ PRESSURE AT SYSTEM INTERFACE.
	CODE 208 - ELECTROLYSIS MODULE CURRENT (I766) > 60 AMPS. (2 OCCASIONS)	ERROR IN SOFTWARE CODE CORRECTED; NEW PROM BOARD INSTALLED.
4-18-95	CODE 225 - LOW RECIRCULATION FLOW (2 OCCASIONS)	CHANGE FLOW COMMAND ON PUMP FROM 0.48 GPM TO 0.55 GPM
4-20-95	CODE 225 - LOW RECIRCULATION FLOW	CHANGE FLOW COMMAND ON PUMP FROM 0.48 GPM TO 0.55 GPM
	CODE 119 - FACILITY WATER INLET VALVE (ITEM 081-1) OPEN TOO LONG	DI WATER SYSTEM WAS TEMPORARILY S/D FOR ROUTINE MAINTENANCE - NO ACTION REQ'D.
	CODE 224 - HIGH DP S/D - H ₂ PHASE SEPARATOR	TESTING DIFFERENT CURRENT RAMPING RATES - NO ACTION REQUIRED
	CODE 225 - LOW RECIRCULATION FLOW	REDUCE SENSITIVITY OF FLOW SWITCH - APPEARS ANY SLIGHT PERTURBATION IN FLOW INITIATES A SHUTDOWN.
4-25-95	CODE 225 - LOW RECIRCULATION FLOW	CHANGE FLOW COMMAND ON PUMP FROM 0.48 GPM TO 0.52 GPM
4-26-95	CODE 018 - ILLEGAL INTERRUPT REQ'D - BITE SHUTDOWN	CHECK CONNECTORS ON BITE BOARD
	CODE 230 - LOW RECIRCULATION LOOP BELOWS ACCUMULATOR (ITEM 606)	TEMPORARY SOLUTION - CHANGE "LOWSIDEV" TO 1 IN ³ - FINAL SOLUTION TO BE DETERMINED WHEN RELIABILITY NETWORK RETURNS
	CODE 225 - LOW RECIRCULATION FLOW	CHANGE FLOW COMMAND ON PUMP FROM 0.48 GPM TO 0.52 GPM (RETURNED TO 0.48 GPM AFTER CODE 018 ANOMALY - BATTERY BACK-UP BYPASSED)
	CODE 225 - LOW RECIRCULATION FLOW	CHANGE FLOW COMMAND ON PUMP FROM 0.52 GPM TO 0.55 GPM - WILL NEED TO RE-CHECK FLOW SWITCH SENSITIVITY IN NEAR FUTURE
4-27-95	CODE 230 - LOW RECIRCULATION LOOP BELOWS ACCUMULATOR (ITEM 606)	SEE ABOVE.
	CODE 225 - LOW RECIRCULATION FLOW	SEE ABOVE - NEED TO CHECK FLOW SWITCH SENSITIVITY
4-29-95	CODE 225 - LOW RECIRCULATION FLOW	SEE ABOVE - RE-CHECK SWITCH AS AWAY, S/I.
5-1-95	CODE 225 - LOW RECIRCULATION FLOW	SWITCH RECALIBRATED FOR LOW FLOW S/D AT 0.27 GPM - S/D VERIFIED - NO ACTION REQ'D. PERMANENTLY CHANGED FLOW COMMAND TO 0.60 GPM - NO IMPACT ON H/X SIZING.

DATE	ANOMALY	ACTION TAKEN
5-4-95 5-5-95	CODE 225 - LOW RECIRCULATION FLOW	REMOVE DI BED - CONCERN IT BEHAVED AS A GAS TRAP
5-7-95	CODE 225 - LOW RECIRCULATION FLOW (2 OCCASIONS)	ROTATE OXYGEN PHASE SEPARATOR 90° SUCH THAT IT NO LONGER BEHAVES AS A 1-G GAS TRAP
	CODE 112 - FEED WATER BELLOW NOT FILLING PROPERLY (RATE IMBALANCE)	OCCURRED WHILE IN MANUAL MODE WHEN ITEM 003 ROTATED - EXRUL IN 5/G CODE - CODE FIXED
5-8-95	CODE 210 - LOW H ₂ PUMP VOLTAGE	NEED TO TROUBLESHOOT CIRCUIT - TO BE DONE AT A LATER DATE.
5-9-95	CODE 225 - LOW RECIRCULATION FLOW	INCREASE TIMER SETPOINT FROM 10 TO 20 SECONDS
	CODE 210 - LOW H ₂ PUMP VOLTAGE	INSTALLED SEPARATE POWER SUPPLY; BYPASS CONTROL CIRCUIT (MANUAL STARTING); PERMANENT REPAIR AFTER CUSTOMER VISIT
	CODE 207 - LOW ELECTROLYSIS CELL VOLTAGE	E28 BREAKER WAS TURNED OFF TO EFFECT INSTALLATION OF SEPARATE POWER SUPPLY - TURN BREAKER BACK ON.
	CODE 216 - COMBUSTIBLE GAS SENSOR MALFUNCTION	DEMONSTRATED FAILURE FOR CUSTOMER VISIT
5-12-95	FAILED POWER SUPPLY / CIRCUIT; LOW RECIRCULATION FLOW S/D'S.	<ul style="list-style-type: none"> - BEGON WORK TO REPAIR/REPLACE DAMAGED HARDWARE IN POWER SUPPLY CABLE - INSTALL TRANSLUCENT PFA TUBING IN RECIRCULATION LOOP, VCR W/CAMERA AND DATA STRIP CABLE REORDER TO TROUBLESHOOT LOW FLOW CONDITION. - WORK COMPLETED ON 5-19.
5-19-95	CODE 213 - LOW H ₂ PRESSURE	ITEM 003 (N.O.) PURGE VALVE FAILED DUE TO BURNED OUT COIL. REPLACE VALVE W/ SPARE N.O. VALVE; RESTART. VALVE RETURNED TO VENDOR FOR REPAIR.
5-21-95	CODE 112 - IMPROPER BELLOW FILLING BELOW ^{RATE} IMBALANCE)	SUSPECT NOISE ON DATA LINE - DATA DOES NOT SUPPORT FAILURE CONDITION. TIMER ESTABLISHED TO PREVENT SPURIOUS S/D'S.
5-23-95	NO SHUTDOWN, BUT TEMPORARY LOSS OF FLOW RECORDED (STRIP CABLE AND VCR CAMERA)	RECORDED GAS SLUGS EXITING BELLOW ACCUMULATOR. REFLOWING LOOP TO DIRECT FLOW FROM PHASE SEPARATOR OUTLET TO PUMP INLET, W/ BELLOW IN TEX CONFIGURATION. BELLOW BEHAVING AS GAS TRAP DUE TO CONFIGURATION OF PORTING AT TIP OF TANK.



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